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(22) International Filing Date: 24 November 1999 (24.11.99)		(74) Agents: BRAINARD, Charles, R. et al.; Kenyon & Kenyon, One Broadway, New York, NY 10004 (US).	
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(71) Applicant (for all designated States except BB US): TEVA PHARMACEUTICAL INDUSTRIES LTD. [IL/IL]; 5 Basel Street, P.O. Box 3190, 49131 Petah Tiqva (IL).		Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>	
(71) Applicant (for BB only): TEVA PHARMACEUTICALS USA, INC. [US/US]; 1515 Delp Drive, Kulpville, PA 19443 (US).			
(72) Inventors; and (75) Inventors/Applicants (for US only): SCHWARTZ, Eduard [IL/IL]; Remez 70, Rechovot (IL). NIDAM, Tamar [IL/IL]; Rechov Weizman 53/40, Yehud (IL). LIBERMAN, Anita [IL/IL]; Rechov Ben-Joseph 28, Tel-Aviv (IL). MENDE- LOVICI, Marioara [IL/IL]; Rechov Hadar 6/12, Rechovot (IL). ARONHEIM, Jehudit [IL/IL]; 9 Havalutzky Street, 44242 Kfar Saba (IL). SINGER, Claude [IL/IL]; 8 David			
(54) Title: SERTRALINE HYDROCHLORIDE POLYMORPHS			
(57) Abstract <p>The present invention is directed to forms II, III, V, VI, VII, VIII, IX and X of sertraline hydrochloride and novel methods for their preparation. According to the present invention, sertraline hydrochloride polymorph II may be produced by slurring sertraline hydrochloride polymorph VI in aprotic organic solvent. Sertraline hydrochloride polymorphic form III may be produced by heating sertraline hydrochloride polymorphs V and VI. Sertraline hydrochloride forms V and VI may be produced from either sertraline hydrochloride or sertraline base by crystallization. Sertraline hydrochloride Form VII may be produced by suspending sertraline chloride polymorph V in water, followed by filtration. Sertraline hydrochloride Forms VIII and IX may be produced by suspending sertraline base in water followed by acidification and filtration. Sertraline hydrochloride Form X and be produced by suspending sertraline hydrochloride in benzyl alcohol with heating, followed by filtration.</p>			

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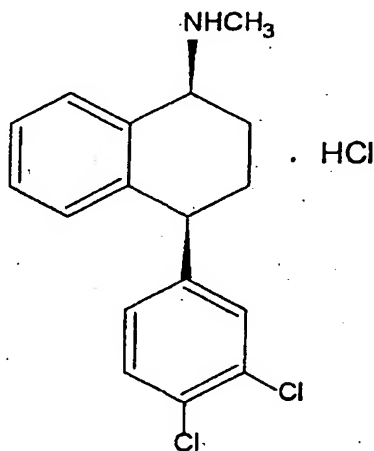
SERTRALINE HYDROCHLORIDE POLYMORPHS

FIELD OF THE INVENTION

5 The present invention relates to novel crystalline forms of sertraline hydrochloride, (1S-cis)-4-(3,4-dichlorophenyl)-1,2,3,4-tetrahydro-N-methyl-1-naphthalenaminehydrochloride, denominated Forms VI through X, an amorphous form and novel, reproducible methods for preparing them and for preparing previously reported polymorphs II, III and V.

BACKGROUND OF THE INVENTION

0 Sertraline hydrochloride, (1S-cis)-4-(3,4 dichlorophenyl)-1,2,3,4-tetrahydro-N-methyl-1-naphthalenamine hydrochloride, having the formula



is approved, under the trademark Zoloft®, by the U.S. Food and Drug Administration, for the treatment of depression, obsessive-compulsive disorder and panic disorder.

U.S. Patent No. 4,536,518 describes a synthesis of sertraline hydrochloride. U.S. Patent No. 5,248,699 describes five crystalline forms of sertraline hydrochloride, designated Form I,

Form II, Form III, Form IV and Form V.

U.S. Patent 4,536,518 ("the '518 patent") describes the preparation of sertraline hydrochloride with a melting point of 243-245°C by treating an ethyl acetate/ether solution of the free base with gaseous hydrogen chloride. The solid state properties of the sertraline hydrochloride so produced are not otherwise disclosed.

According to U.S. Patent No. 5,248,699 ("the '699 patent"), the sertraline hydrochloride produced by the method of the '518 patent has a crystalline form denominated "Form II". The '699 patent discloses four other polymorphs I, III, IV, and V, and characterizes them by single crystal x-ray analysis, powder x-ray diffraction, infra-red spectroscopy, and differential scanning calorimetry. The '699 patent reports that Form II is produced by rapid crystallization of sertraline hydrochloride from an organic solvent, including isopropyl alcohol, hexane, generally describes methods for making sertraline hydrochloride Forms I-V. According to this patent, the preferential formation of Forms I, II or IV in an acidic solution consisting of isopropyl alcohol, hexane, acetone, methyl isobutyl ketone, glacial acetic acid, or preferably, ethyl acetate depends on the rapidity of crystallization. Form I is described as being made by crystallizing sertraline hydrochloride in an acidic solution using an organic solvent such as those listed above. The crystallization of Form I is carried out at a temperature from about 20°C to about the solvent reflux temperature, preferably from about 40° to 60°C. The only method described in this patent for making Forms II and IV is by the rapid crystallization of sertraline hydrochloride from an organic solvent such as those listed above. Slow crystallization or granulation of sertraline hydrochloride will produce Form I. Form III is described as being formed by heating Forms I, II or IV to temperatures above about 180° C. Granulating either of Forms II, III or

IV in isopropyl alcohol, ethyl acetate, hexane or any of the solvents listed above at a temperature from about 40° to 60° C causes conversion to Form I. The only method described in this patent for making Form V is by sublimation of sertraline hydrochloride Form I at reduced pressure and at a temperature from about 180-190° C onto a condenser. However, in our hands attempts to repeat this procedure to obtain Form V have been unsuccessful.

SUMMARY OF THE INVENTION

It has now been discovered that sertraline hydrochloride Form V can be formed by crystallization from various solvents rather than by sublimation. The existence of new crystal forms of sertraline hydrochloride, denominated Forms VI, VII, VIII, IX and X, and an amorphous of sertraline hydrochloride have been discovered. Form VI is a useful intermediate in the formation of previously reported sertraline hydrochloride Forms II, II and V.

The present invention also relates to sertraline hydrochloride ethanolate and processes for making sertraline hydrochloride ethanolate.

The present invention also relates to sertraline hydrochloride methanolate and processes for making sertraline hydrochloride methanolate.

The present invention also relates to sertraline hydrochloride solvate and processes for making sertraline hydrochloride solvate.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a characteristic x-ray powder diffraction spectrum of sertraline hydrochloride Form V.

Figure 2 is a characteristic x-ray powder diffraction spectrum of amorphous sertraline hydrochloride Form V.

Figure 3 is a characteristic differential scanning calorimetric (DSC) thermogram of sertraline hydrochloride Form V.

5 Figure 4 is a characteristic infrared (IR) absorption spectrum of sertraline hydrochloride Form V.

Figure 5 is a characteristic x-ray powder diffraction spectrum of sertraline hydrochloride Form VI.

0 Figure 6 is a characteristic x-ray powder diffraction spectrum of sertraline hydrochloride Form VII.

Figure 7 is a characteristic x-ray powder diffraction spectrum of sertraline hydrochloride Form VIII.

Figure 8 is a characteristic x-ray powder diffraction spectrum of sertraline hydrochloride Form IX.

5 Figure 9 is a characteristic differential scanning calorimetric (DSC) thermogram of sertraline hydrochloride Form VIII.

Figure 10 is a characteristic differential scanning calorimetric (DSC) thermogram of sertraline hydrochloride Form IX.

) Figure 11 is a characteristic infrared (IR) absorption spectrum of sertraline hydrochloride Form VIII.

Figure 12 is a characteristic infrared (IR) absorption spectrum of sertraline

hydrochloride Form IX.

Figure 13 is a characteristic differential scanning calorimetric (DSC) thermogram of sertraline hydrochloride Form VI.

Figure 14 is a characteristic x-ray powder diffraction spectrum of sertraline
5 hydrochloride Form X

Figure 15 is a characteristic infrared (IR) absorption spectrum of sertraline hydrochloride Form X.

Figure 16 is a characteristic differential scanning calorimetric (DSC) thermogram of sertraline hydrochloride Form X.

DETAILED DESCRIPTION OF THE INVENTION

Form V

The present invention provides new processes for making sertraline hydrochloride Form V from sertraline hydrochloride, sertraline base or amorphous sertraline hydrochloride. The methods provided in the present invention are more commercially practicable than the sublimation-
5 condensation method of U.S. Patent No. 5,248,699, which we have not been able to reproduce. It has also surprisingly been found that, by the present method, Form V is formed even at different crystallization rates.

Where the present invention provides methods for the conversion of sertraline
0 hydrochloride to sertraline hydrochloride Form V, sertraline hydrochloride is combined with a solvent selected from the group consisting of methanol, ethanol, 1-methoxy-2-propanol and a mixture of isopropyl alcohol and water. If a mixture of isopropyl alcohol and water is used, it is preferably an about 6:1 mixture. Preferably the solvent is methanol or ethanol, and most preferably the solvent is ethanol. Sertraline hydrochloride Form V is isolated by allowing the solution to cool. One preferred
5 method is to rapidly cool the solvent to 5°C. Another preferred method comprises seeding the solution with sertraline hydrochloride Form V crystals, followed by slow cooling to room temperature, followed by filtration and drying. Sertraline hydrochloride Form V can also be prepared by recrystallizing sertraline hydrochloride Form VI (described below) from water.

The present invention also provides methods for the conversion of sertraline hydrochloride Form II or II to sertraline hydrochloride Form V wherein the solvate sertraline hydrochloride Form VI is an intermediate. In this embodiment of the present invention, sertraline

hydrochloride Form I and Form II is dissolved in either methanol or ethanol thereby forming sertraline hydrochloride Form VI. Where ethanol is the solvent, the sertraline hydrochloride Form VI is the ethanolate solvate. Where methanol is the solvent, the sertraline hydrochloride Form VI is the methanolate solvate. This intermediate sertraline hydrochloride Form VI is then dried, with or without a
5 separate isolation step, to remove all solvent and sertraline hydrochloride Form V is isolated.

The present invention also provides methods for the conversion of sertraline hydrochloride Form II to sertraline hydrochloride Form V wherein the sertraline hydrochloride Form VIII is an intermediate. In this embodiment of the present invention, sertraline hydrochloride Form II is dissolved in water thereby forming sertraline hydrochloride Form VIII. This intermediate sertraline
0 hydrochloride Form VIII is then dried, with or without a separate isolation step, to remove all solvent and sertraline hydrochloride Form V is isolated.

The present invention also provides methods for the conversion of sertraline base to sertraline hydrochloride Form V, wherein sertraline base is added to at least one solvent, and hydrogen chloride gas is bubbled through the solution. Preferred solvents include methanol, ethanol, water, or
5 mixtures of ethanol, methanol, isopropyl alcohol, hexane, ethyl acetate with each other or with water. Alternatively, an appropriate amount of hydrogen chloride gas dissolved in methanol, ethanol, water, hexane, isopropyl alcohol, ethyl acetate, or a mixture thereof is combined with the sertraline base solution. Sertraline hydrochloride Form V is isolated by allowing precipitation to occur from about 0° to about 60°C followed by filtration and drying. Preferably the solvent is hexane, isopropyl alcohol or a
mixture thereof. In another method, sertraline base is added to a solvent and the resulting solution is added to a hydrochloric acid solution of pH 0-4; preferably the pH of the solution is about 1.

Alternatively, sertraline base is added to a solvent selected from the group consisting of methanol, ethanol, water, hexane, isopropyl alcohol, and ethyl acetate or a mixture thereof. The solution is heated and concentrated hydrochloric acid is added. Water may also be added. Sertraline hydrochloride Form V is isolated by allowing the mixture to cool to room temperature and remain at room temperature overnight, followed by filtration and drying.

Alternatively, sertraline base may be combined with a solvent selected from the group consisting of ethanol, ethanol and water, ethyl acetate, and a mixture of ethyl acetate and water. The solution is heated to about 50-60°C and water is added. The solvent is partially removed by distillation. Sertraline hydrochloride Form V is isolated by allowing the solution to cool to room temperature, followed by filtration and drying at the precipitate.

Alternatively, sertraline base may be combined with a solvent selected from the group consisting of methanol, ethanol and a mixture thereof. A saturated solution of hydrogen chloride gas in isopropyl alcohol is added to induce formation of sertraline hydrochloride Form V. Sertraline hydrochloride Form V is isolated by allowing the solution to stand at room temperature overnight, followed by filtration and drying of the precipitate.

Sertraline base for use in the processes of the present invention may be produced by dissolving sertraline mandelate in ethyl acetate followed by neutralization of the sertraline mandelate with aqueous sodium hydroxide. The organic phase is separated from the aqueous phase and dried using magnesium sulfate. The solvent is removed under reduced pressure to produce sertraline base as an oil. Methods for making sertraline base are set forth in U.S. Patent Nos. 4,536,518 and 5,248,699.

Where the present invention provides methods for the conversion of amorphous

sertraline hydrochloride to sertraline hydrochloride Form V, amorphous sertraline hydrochloride is kept in a closed container, such as a bag, and warmed to about 40° C to about 80° C or is stored at room temperature for a period between a few hours and several days depending on the temperature.

The sertraline hydrochloride Form V that results from practicing the invention as exemplified herein can be characterized by its powder X-ray diffraction pattern. Figure 1 is a representative pattern of sertraline hydrochloride Form V. The principal peaks observed are at about 5.2° ±0.2, 10.4° ±0.2, 11.0° ±0.2, 14.3° ±0.2, 16.5° ±0.2, 17.3° ±0.2, 18.4° ±0.2, 19.1° ±0.2, 19.7° ±0.2, 20.9° ±0.2, 22.0° ±0.2, 23.2° ±0.2, 23.6° ±0.2, 25.5° ±0.2, 26.0° ±0.2, and 29.1° ±0.2 degrees 2 theta.

Three experiments were performed in order to repeat the procedure described in U.S. Patent No. 5,248,699 for preparing Form V by sublimation. Two experiments were performed by sublimating a sample of Form I under 30 mm Hg vacuum and temperature between 170-190°C. A third experiment was performed by sublimating a sample of Form I under high vacuum (0.1 mm Hg) and temperature between 180-195°C.

The three samples of sertraline hydrochloride prepared by sublimation were analyzed by powder x-ray diffraction. In all cases, the typical broad featureless pattern without sharp peaks typical of amorphous materials was obtained. Figure 2 is one such pattern.

In conclusion, sertraline hydrochloride could not be obtained by following the procedure set forth in U.S. Patent No. 5,248,699 for preparing Form V by sublimation of Form I.

The IR spectrum of sertraline hydrochloride Form V produced by the present process is characterized by the following bands: 773 cm⁻¹, 822 cm⁻¹, cm⁻¹, 1012 cm⁻¹, 1032 cm⁻¹, 1054 cm⁻¹,

1133 cm^{-1} , 1328 cm^{-1} , 1562 cm^{-1} , and 1590 cm^{-1} , as shown in Figure 4.

The sertraline hydrochloride Form V of the present process is further characterized by the DSC thermogram data, for example, as disclosed in Figure 3. The DSC thermogram is characterized by a small endotherm (~3 Joule per gram) at about 210°C, believed to be a solid-solid transformation (based upon observation under a hot stage microscope) to Form III, and a melting peak. Form III at 251°C

Form VI

Sertraline hydrochloride Form VI is a solvated crystal form of sertraline hydrochloride. In the present invention, sertraline hydrochloride Form VI may be an ethanolate, wherein ethanol is incorporated into the crystal structure of Form VI. Alternatively, sertraline hydrochloride Form VI may be a methanolate, wherein methanol is incorporated into the crystal structure of sertraline hydrochloride Form VI. All sertraline hydrochloride Form VI solvates have identical powder x-ray diffraction patterns. Therefore, when referring to sertraline hydrochloride Form VI all sertraline hydrochloride Form VI solvates such as, sertraline hydrochloride Form VI ethanolate and sertraline hydrochloride Form VI methanolate, are necessarily included.

To form the novel crystalline form sertraline hydrochloride Form VI, sertraline base is added to absolute ethanol or methanol. Hydrogen chloride gas is then bubbled through the solution. Sertraline hydrochloride Form VI is isolated by allowing precipitation to occur, followed by filtration. The DSC thermogram of Form VI crystallized from ethanol displays a desolvation peak at 95°C (see Fig. 13) and loses 11.2% weight (by TGA); Form VI crystallized from methanol loses 8.3 % weight (by TGA) upon desolvation; Form VI crystallized from ethanol is an ethanolate, and more specifically is a

monoethanolate. Form VI crystallized from methanol is a methanolate, and more specifically is a monomethanolate.

The present invention also provides new processes for making sertraline hydrochloride ethanolate Form VI by reslurry of Forms I, II and V. In the conversion of sertraline hydrochloride Form I, II, V to sertraline hydrochloride ethanolate Form VI, sertraline hydrochloride Form I, II or V is dissolved or suspended in ethanol or in methanol and stirred for about 18-36 hours, 24 hours is preferred. Sertraline hydrochloride ethanolate Form VI is isolated by filtration.

The sertraline hydrochloride Form VI so isolated exhibits the powder x-ray diffraction pattern of Figure 5, comprising peaks at $7.3^{\circ} \pm 0.2$, $12.1^{\circ} \pm 0.2$, $12.7^{\circ} \pm 0.2$, $14.0^{\circ} \pm 0.2$, $15.6^{\circ} \pm 0.2$, $17.6^{\circ} \pm 0.2$, $20.1^{\circ} \pm 0.2$, $20.6^{\circ} \pm 0.2$, $21.9^{\circ} \pm 0.2$, $22.7^{\circ} \pm 0.2$, $23.0^{\circ} \pm 0.2$, $23.8^{\circ} \pm 0.2$, $24.3^{\circ} \pm 0.2$, $25.4^{\circ} \pm 0.2$, and $26.3^{\circ} \pm 0.2$ degrees two-theta. Sertraline hydrochloride Form VI so obtained is a solvate. Drying of the precipitated sertraline hydrochloride Form VI at 50-60°C overnight yields sertraline hydrochloride Form V.

Form VII

It has also been discovered that a new crystalline form of sertraline hydrochloride Form VII, may be obtained by suspending Form V in water, and filtrating the suspension after one day without further drying.

In another embodiment of the invention, sertraline hydrochloride Form VII is made from sertraline hydrochloride Form VI. Sertraline hydrochloride Form VI is dispersed in water and the mixture is heated to facilitate the dissolution of sertraline hydrochloride Form VI. The solution may be

heated to about 30° C to 90° C, preferably to about 80° C. The pH is then lowered, preferably to about pH 1 and the mixture is allowed to cool to room temperature and stirred until the reaction is complete. Preferably the reaction is stirred for two hours at room temperature. Sertraline hydrochloride Form VII is isolated by filtration and washing with water.

As shown in Figure 6, sertraline hydrochloride Form VII is characterized by two unique strong x-ray powder diffraction peaks at $4.0^{\circ} \pm 0.2$, and 20.0 degrees two-theta and medium intensity peaks at $8.0^{\circ} \pm 0.2$, $11.6^{\circ} \pm 0.2$, $12.0^{\circ} \pm 0.2$, $13.8^{\circ} \pm 0.2$, $16.5^{\circ} \pm 0.2$, $22.8^{\circ} \pm 0.2$, $24.1^{\circ} \pm 0.2$, $25.0^{\circ} \pm 0.2$, $26.6^{\circ} \pm 0.2$, $30.7^{\circ} \pm 0.2$, $34.7^{\circ} \pm 0.2$ two-theta. The TGA curve shows a loss on drying of about 45%.

Forms VIII and IX

Additional new crystalline forms of sertraline hydrochloride, Forms VIII and IX, have also been discovered. Sertraline hydrochloride hydrate Form VIII may be produced by suspending sertraline base in water followed by acidification and filtration. Form IX is obtained by drying of Form VIII. Preferably the sertraline base is suspended in water, heated to approximately 80°C, adding hydrochloric acid to reduce the pH to about 1, and cooling the resulting solution to room temperature.

The present invention also provides new processes for making sertraline hydrochloride Form VIII from sertraline hydrochloride ethanolate Form VI. In one embodiment of the present invention, a slurry of sertraline hydrochloride ethanolate Form VI in water is stirred, preferably for about one hour. The slurry is then filtered and washed with water and sertraline hydrochloride hydrate Form VIII is isolated.

The present invention also provides precesses of making sertraline hydrochloride form

VIII from sertraline hydrochloride Form II. In the conversion of sertraline hydrochloride Form II to sertraline hydrochloride Form VIII, sertraline hydrochloride Form II is suspended in water and stirred, preferably stirred overnight and sertraline hydrochloride hydrated Form VIII is isolated by filtration.

Sertraline hydrochloride Form VIII is characterized by x-ray powder diffraction peaks at $4.7^{\circ}\pm 0.2$, $11.8^{\circ}\pm 0.2$, $16.3^{\circ}\pm 0.2$, $17.8^{\circ}\pm 0.2$, $19.6^{\circ}\pm 0.2$, $23.2^{\circ}\pm 0.2$, $24.2^{\circ}\pm 0.2$, $25.1^{\circ}\pm 0.2$, and $26.0^{\circ}\pm 0.2$ two-theta, as described in Figure 7.

The DSC thermogram for Form VIII is characterized by a strong endotherm below 100°C , small endothermic and exothermic events at about 220°C and a melting peak at 247°C as described in Figure 9.

The TGA curve shows a loss on drying step of about 20% below 100°C .

The IR spectrum of Form VIII is characterized by the following bands: 740 cm^{-1} , 779 cm^{-1} , 822 cm^{-1} , 887 cm^{-1} , 915 cm^{-1} , 1031 cm^{-1} , 1053 cm^{-1} , 1110 cm^{-1} , 1134 cm^{-1} , 1153 cm^{-1} , 1217 cm^{-1} , 1307 cm^{-1} , and 1377 cm^{-1} , as described in Figure 11.

Sertraline hydrochloride Form IX is characterized by x-ray powder diffraction peaks at $5.1^{\circ}\pm 0.2$, $14.2^{\circ}\pm 0.2$, $15.8^{\circ}\pm 0.2$, $16.8^{\circ}\pm 0.2$, $19.2^{\circ}\pm 0.2$, $19.7^{\circ}\pm 0.2$, $22.4^{\circ}\pm 0.2$, $23.2^{\circ}\pm 0.2$, $25.3^{\circ}\pm 0.2$ and $26.1^{\circ}\pm 0.2$ two-theta, as described in Figure 8.

The IR spectrum of Form IX is characterized by the following bands: 701 cm^{-1} , 715 cm^{-1} , 741 cm^{-1} , 758 cm^{-1} , 780 cm^{-1} , 816 cm^{-1} , 823 cm^{-1} , 1030 cm^{-1} , 1053 cm^{-1} , 1078 cm^{-1} , 1110 cm^{-1} , 1204 cm^{-1} , 1217 cm^{-1} , 1307 cm^{-1} , and 1350 cm^{-1} , as described in Figure 12.

Form X

It has further been discovered that another crystalline form of sertraline hydrochloride,

denominated Form X, may be obtained by suspending sertraline hydrochloride in benzyl alcohol heating to facilitate dissolution. The precipitate is then filtered, washed with benzyl alcohol and dried, to yield sertraline hydrochloride Form X.

The Form X produced in this manner is characterized by a powder x-ray diffraction pattern having its principal peaks at $15.0^{\circ} \pm 0.2$, $16.0^{\circ} \pm 0.2$, $16.5^{\circ} \pm 0.2$, $17.0^{\circ} \pm 0.2$, $18.1^{\circ} \pm 0.2$, $21.0^{\circ} \pm 0.2$, $22.4^{\circ} \pm 0.2$, $24.9^{\circ} \pm 0.2$, $25.4^{\circ} \pm 0.2$, $26.2^{\circ} \pm 0.2$, $27.1^{\circ} \pm 0.2$, $28.4^{\circ} \pm 0.2$, and $29.0^{\circ} \pm 0.2$ degrees two-theta as described in Figure 14.

The IR spectrum of Form X is characterized by the following bands: 742 cm^{-1} , 776 cm^{-1} , 806 cm^{-1} , 824 cm^{-1} , 1002 cm^{-1} , 1017 cm^{-1} , 1028 cm^{-1} , 1060 cm^{-1} , 1079 cm^{-1} , 1135 cm^{-1} , 1218 cm^{-1} , 1314 cm^{-1} , 1336 cm^{-1} , and 1560 cm^{-1} as described in Figure 15.

The DSC of Form X shows a small endotherm at about 190°C followed by a melting endotherm at about 250°C , (see Figure 16).

Form II

The present invention provides new processes for making sertraline hydrochloride Form II from sertraline hydrochloride Form VI by reslurry or granulation in organic solvents at temperatures between $25\text{--}80^{\circ}\text{C}$, followed by drying. The methods provided in the present invention have advantages over the rapid recrystallization method of U.S. Patent No. 5,248,699. The method of the present invention does not require complete dissolution of sertraline hydrochloride, controlling the rate of heating or cooling of a sertraline solution, or controlling the rate of crystallization. The present method utilizes less solvent than the method of the '699 patent, since the sertraline hydrochloride starting material need not be completely dissolved.

In the conversion of sertraline hydrochloride Form VI to sertraline hydrochloride Form II, sertraline hydrochloride Form VI is combined with an aprotic organic solvent. Suitable solvents include acetone, t-butyl-methyl ether (MTBE), ethyl acetate and cyclohexane. One preferred method is to heat sertraline hydrochloride Form VI and solvent, preferably MTBE, to reflux for one hour. The slurry is cooled to room temperature and sertraline hydrochloride Form II is isolated by filtration. Another preferred method of making sertraline hydrochloride Form II comprises stirring sertraline hydrochloride Form VI and suitable solvent, preferably acetone, at room temperature for 2 hours, followed by filtration. About 1 to about 10 volumes of solvent are preferred, based on the weight of the sertraline hydrochloride starting material. See Examples 9 (3 volumes of solvent) and 10 (5 volumes of solvent) below. However, smaller amounts of solvent will also effect the transformation, albeit in some instances more slowly. The reaction is carried out for a time sufficient to convert the Form VI to Form II. We have not observed any further conversion of Form II upon treatment under these conditions for times longer than the minimum time necessary to effect the transformation.

The present invention also provides new processes for making sertraline hydrochloride Form II from sertraline hydrochloride Form V by granulation. In the conversion of sertraline hydrochloride Form V to sertraline hydrochloride Form II, sertraline hydrochloride Form V is combined with ethanol. The sertraline hydrochloride Form V ethanol mixture is stirred for at least a few hours to several days, preferably about two days to induce the formation of sertraline hydrochloride Form II.

Sertraline hydrochloride Form II may also be made by recrystallization of sertraline hydrochloride from suitable solvents such as dimethyl formamide or cyclohexanol. Sertraline

hydrochloride is dissolved by warming in the solvent followed by cooling the solution at room temperature. Sertraline Form II is isolated by filtration.

The present invention also provides a new process for making sertraline hydrochloride Form II from sertraline base. Sertraline base is dissolved in a suitable such as acetone and the pH of the solution is lower by the addition of a hydrogen chloride solution, such as isopropyl alcohol and hydrogen chloride. The hydrogen chloride solution is added to induce the formation of sertraline hydrochloride Form II. Upon cooling of the mixture, for example to room temperature, sertraline hydrochloride Form II is isolated by filtration.

An experiment was performed in order to repeat the procedure described in U.S. Patent No. 4,536,518 for preparing Form II. Sertraline base was dissolved in ethyl acetate, ether was added and the solution was acidified with hydrogen chloride gas. The material obtained after filtration and air drying was sertraline hydrochloride amorphous, not Form II as was expected.

The present invention also provides new processes for making a mixture of sertraline hydrochloride Form II and sertraline hydrochloride Form V. In this embodiment of the present invention, sertraline hydrochloride Form VI is heated to induce the transformation of sertraline hydrochloride Form VI to a mixture of both sertraline hydrochloride Form II and sertraline hydrochloride Form V. In this embodiment of the present invention, the heating of sertraline hydrochloride Form VI may be done under reduced pressure or atmospheric pressure.

Form III

The present invention provides new processes for making sertraline hydrochloride Form III from sertraline hydrochloride Form V. In the conversion of sertraline hydrochloride Form V

to sertraline hydrochloride Form III, Form V is heated to a temperature between about 150° to about 180° C for about 24 hours to induce the formation of sertraline hydrochloride Form III. The reaction may be stirred. The method of the present invention has the advantage of using no solvent.

The methods of the present invention also provides new processes for making sertraline hydrochloride Form III from sertraline hydrochloride ethanolate Form VI by heating sertraline hydrochloride Form VI at about 150° to about 180° C for about 24 hours. The dried material is sertraline hydrochloride Form III.

Amorphous Sertraline Hydrochloride

The present invention provides new processes for making amorphous sertraline hydrochloride from sertraline hydrochloride by sublimation or by precipitating, from a non-polar solvent such as toluene, ether and t-butyl-methyl ether sertraline base.

In an embodiment of the present invention, amorphous sertraline is made by dissolving hydrochloride Form V in water and drying the solution by the spray dryer technique. Amorphous sertraline hydrochloride may also be made by sublimation of sertraline hydrochloride.

The amorphous sertraline hydrochloride produced by methods of the present invention is characterized by a powder x-ray diffraction pattern having the typical broad featureless pattern without sharp peaks typical of amorphous materials. Figure 2 is one such pattern.

Pharmaceutical Compositions Containing Sertraline Hydrochloride Polymorphs

In accordance with the present invention, these new crystalline forms of sertraline hydrochloride and known forms of sertraline hydrochloride prepared by the new methods disclosed herein may be prepared as pharmaceutical compositions that are particularly useful for the treatment of depression, obsessive-compulsive disorder and panic disorder. Such compositions comprise one of the new crystalline forms of sertraline hydrochloride with pharmaceutically acceptable carriers and/or excipients known to one of skill in the art.

For example, these compositions may be prepared as medicaments to be administered orally, parenterally, rectally, transdermally, buccally, or nasally. Suitable forms for oral administration include tablets, compressed or coated pills, dragees, sachets, hard or gelatin capsules, sub-lingual tablets, syrups and suspensions. Suitable forms of parenteral administration include an aqueous or non-aqueous solution or emulsion, while for rectal administration suitable forms for administration include suppositories with hydrophilic or hydrophobic vehicle. For topical administration the invention provides suitable transdermal delivery systems known in the art, and for nasal delivery there are provided suitable aerosol delivery systems known in the art.

Experimental

The powder X-ray diffraction patterns were obtained by methods known in the art using a Philips X-ray powder diffractometer, Goniometer model 1050/70 at a scanning speed of 2° per minute, with a Cu radiation of $\lambda = 1.5418 \text{ \AA}$

The differential scanning calorimeter thermograms were obtained by methods known in the art using a DSC Mettler 821 Star°. The weight of the samples was less than 5 mg. The temperature range of scans was 30°C-300°C at a rate of 10°C/min. Samples were purged with

nitrogen gas at a flow rate of 40 mL/min. Standard 40 μ l aluminum crucibles were used having lids with three small holes.

The infrared spectra were obtained by methods known in the art using a Perkin Elmer FT-IR Paragon 1000 spectrometer. Samples were analyzed in Nujol mulls. Spectra were obtained at 4 cm^{-1} resolution and 16 scans each.

EXAMPLES

The present invention will now be further explained in the following examples. However, the present invention should not be construed as limited thereby. One of ordinary skill in the art will understand how to vary the exemplified preparations to obtain the desired results.

Example 1

Preparation of Sertraline Base

Sertraline mandelate (5 g) was stirred at room temperature with 50 mL ethyl acetate. Aqueous sodium hydroxide was added dropwise until the sertraline mandelate was completely neutralized. The phases were separated and the organic phase was dried over MgSO_4 and filtered. The solvent was removed under reduced pressure resulting sertraline base as an oil (3.2 g).

Example 2

Preparation of Sertraline Hydrochloride Form VI and Form V

Sertraline base (25 g) was dissolved in methanol (125 mL) at room temperature. The solution was acidified with hydrogen chloride until pH 1.5 was reached. (Precipitation occurred during acidification.) The temperature rose to approximately 40°C. The slurry was allowed to cool to room temperature and stirred for about 2 hours. The solid was separated by filtration to give sertraline

hydrochloride methanolate-Form VI. Drying the product overnight gave sertraline hydrochloride Form V.

Example 3

Preparation of Sertraline Hydrochloride Form VI and Form V

Sertraline base (3.2 g) was dissolved in absolute ethanol (32 mL) at room temperature and then hydrogen chloride gas was bubbled in until pH 0.5 was reached. The temperature rose to 40°C. The slurry was allowed to cool to room temperature and stirred for about 16 hours. The solid was separated by filtration, and washed with ethanol (3 x 2 mL). Figure 5 sets forth the X-ray diffraction pattern of the product (sertraline hydrochloride Form VI) so obtained. Drying overnight at 50-60°C of that product yields 2.95 g (82%) of sertraline hydrochloride Form V.

Example 4

Preparation of Sertraline Hydrochloride Form V

Sertraline base (3 g) was dissolved in absolute ethanol (15 mL) at room temperature. A saturated solution of hydrogen chloride in isopropyl alcohol was added dropwise to reach a pH of 1.3. The resulting slurry was stirred at room temperature overnight. The solid was separated by filtration and dried overnight at 50-60°C yielding 2.75 g (81.8%) sertraline hydrochloride Form V.

Example 5

Preparation of Sertraline Hydrochloride Form V

Sertraline base (3 g) was dissolved in absolute ethanol (15.5 mL) at room temperature and then the solution was cooled to approximately 0°C. Hydrogen chloride gas was bubbled until pH 0.5 was reached. The temperature rose to approximately 7°C. Precipitation occurred and the slurry was stirred at about 10°C for 2 hours. The solid was isolated by filtration, washed with ethanol and

dried at approximately 50°C. The dried material (2.87 g, yield 82.7%) was sertraline hydrochloride Form V.

Example 6

Preparation of Sertraline Hydrochloride Form V

5 Sertraline base (3 g) was stirred with 35 mL water. The slurry was heated at ~70°C and, while maintaining this temperature, concentrated hydrochloric acid was added until pH 1 was reached. During acidification, almost complete dissolution was observed followed by precipitation. The mixture was cooled to room temperature and stirred for 2 hours. The solid was isolated by filtration, washed with water and dried overnight at 50-60° C, yielding 3.23 g (96%) sertraline
0 hydrochloride Form V.

Example 7

Preparation of Sertraline Hydrochloride Form V

Sertraline base (3 g) was dissolved in 10 mL absolute ethanol at 40°C. The solution was heated to 50°-60°C and concentrated hydrochloric acid 32% (1.2 mL) was added until pH ~1.3
5 was reached. Water (12 mL) was added. The resulting clear solution was concentrated to half its volume and was allowed to cool naturally to room temperature. The solid was isolated by filtration, washed with water and dried overnight at 50-60°C, yielding 3.18 g (94.65%) sertraline hydrochloride Form V.

Example 8

Preparation of Sertraline Hydrochloride Form V

Sertraline base (3.7 g) was dissolved in 18.5 mL absolute ethanol and the solution was heated to 60° C. Hydrogen chloride gas was bubbled through the ethanol solution until pH ~0.5 was

reached. The mixture was cooled to room temperature and the stirring was continued for 2 hours. The solid obtained after filtration, washing with ethanol and drying at 50° C was sertraline hydrochloride Form V (3.16 g, yield 76%).

Example 9

Preparation of Sertraline Hydrochloride Form V

Sertraline free base was dissolved in ethanol absolute and the solution was acidified with hydrogen chloride gas to about pH 3. Precipitation occurs and the slurry was stirred at room temperature for 2 hours. The resulting solid was filtered, washed with ethanol and dried to yield sertraline hydrochloride Form V.

Example 10

Preparation of Sertraline Hydrochloride Form V

Sertraline free base (13.3 g) was dissolved in absolute ethanol (60 mL) and was added dropwise over one hour to ethanol (20 mL) containing hydrogen chloride gas (17.5 g) at 35° C. After 2 hours, the solid was filtrated, washed with ethanol and dried at about 80° C to yield sertraline hydrochloride Form V(12.9 gr., yield 87%).

Example 11

Preparation of Sertraline Hydrochloride Form V

Anhydrous sertraline hydrochloride (2 g) was stirred with 14 mL absolute ethanol and heated to reflux to obtain a clear solution. The solution was seeded with sertraline hydrochloride Form V and cooled naturally to room temperature. Massive precipitation was observed at about 50° C. The

slurry was stirred at room temperature during 2 hours. The solid was filtered, washed with ethanol (3 mL) and dried overnight at 50-60° C yielding 1.71 g (85.5%) of sertraline hydrochloride Form V.

Example 12

Preparation of Sertraline Hydrochloride Form V

Sertraline hydrochloride ethanolate (Form VI) (40 g) in 400 mL water was heated to 80°C and complete dissolution was obtained. The pH was adjusted to approximately one with hydrochloric acid and the solution was naturally cooled to room temperature and stirred for 2 hours. The solid was filtered and dried at 50°C for approximately 16 hours, yielding sertraline hydrochloride Form V.

Example 13

Preparation of Sertraline Hydrochloride Form V

Sertraline hydrochloride ethanolate (Form VI) (2 g) was mechanically stirred with ethanol (0.5 mL) at room temperature for 40 hours. The resulting solid was sertraline hydrochloride Form V.

Table 1 sets forth a summary of additional experiments conducted generally following procedures described above.

TABLE 1 PREPARATION OF SERTRALINE HCL - FORM V
SERTRALINE BASE AS STARTING MATERIAL

<u>Exp't</u>	<u>Method of Crystallization</u>	<u>XRD</u>	<u>Yield</u> (%)
A	Methanol/HCl gas	V	78.7
5 B	Methanol/HCl gas	V	69
C	Methanol/ HCl aqueous	V	87.8
D	Ethanol/HCl gas	V	80.9
E	Water/HCl aqueous	V	96
F	Hexane/Isopropyl alcohol/HCl gas	V	89.9
10 G	Methanol/HCl aqueous/water	V	89
H	Isopropyl alcohol/HCl aqueous/water	V	78
I	Ethanol/HCl aqueous/evaporation of ethanol	V	96.1
J	Ethyl acetate/HCl aqueous/water/evaporation of ethyl acetate	V	96.1
K	Ethanol/isopropyl alcohol/HCl gas	V	81.8
5 L	Methanol/isopropyl alcohol/HCl gas	V	82.4
SERTRALINE HCl AS STARTING MATERIAL			
M	Methanol (Form I and amorphous)	V	60
N	Ethanol (Form V)	V	85.5
0 O	Isopropyl alcohol/water (Form V)	V	28

PXRD = powder x-ray diffraction.

Example 14
Preparation of Sertraline Hydrochloride Form VII

1.003 g Sertraline hydrochloride Form V was stirred for 24 hours at room temperature in 20 mL water (HPLC grade). At the end of the stirring the mixture looked like a jelly suspension. The suspension was filtrated and the compound obtained was kept at cold conditions (4°C) until analyzed by x-ray diffraction.

Example 15

Preparation of Sertraline hydrochloride form VII from Sertraline hydrochloride form VI

A solution of sertraline hydrochloride ethanolate (Form VI) (40 g) in water (400 mL) was heated at 80° C and complete dissolution of sertraline hydrochloride ethanolate (Form VI) was obtained. The pH was adjusted to about 1 and the solution was allowed to cool to room temperature and then stirred for 2 additional hours. The solid was isolated by filtration and washed with water to yield sertraline hydrochloride Form VII.

Example 16

Preparation of Sertraline Hydrochloride Forms VIII and IX

Sertraline base (2.7 g) was suspended in 27 mL of water. This mixture was heated to 80°C and treated with hydrochloric acid until about pH 1 was reached. A clear solution was obtained which on cooling gave a precipitate. After 2 hours stirring at room temperature the solid was isolated by filtration. This solid was characterized by powder x-ray diffraction (see Figure 7). Drying for 24 hours at ~ 50°C yielded 2.32 g (76.8%) of sertraline hydrochloride Form IX, characterized by powder x-ray diffraction, infra-red absorption, differential scanning calorimetry, and thermal gravimetric

analysis as set forth above and depicted in Figures 8, 10, and 12.

Example 17

Preparation of Sertraline hydrochloride Form VIII

5 Sertraline hydrochloride ethanolate (Form VI) (40 g) was stirred with water (80 ml.)
for 1 hour at room temperature. The slurry was filtrated and washed with water to yield sertraline
hydrochloride hydrate- Form VIII.

Example 18

10 **Preparation of Sertraline hydrochloride form VIII from Sertraline hydrochloride form II**

Sertraline hydrochloride Form II (0.4 g) and water (8 mL) were stirred at room
temperature over night. The solid was filtrated to yield sertraline hydrochloride hydrate Form VIII.

Example 19

15 **Preparation of Sertraline Hydrochloride Form II from Form VI**

A slurry of sertraline hydrochloride Form VI (50 g) and t-butyl-methyl-ether (150 ml) were
heated to reflux and the reflux was continued for 1 hour. The slurry was then allowed to cool to room
20 temperature and filtered. The solid was washed with t-butyl-methyl-ether (50 ml) and dried in a
reactor under vacuum of 30 mm Hg with stirring. The dried solid so obtained is sertraline
hydrochloride Form II (38.26 g; yield 86.7 %).

Example 20**Preparation of Sertraline Hydrochloride Form II from Form VI**

Sertraline hydrochloride Form VI (25 g) was stirred with acetone (250 ml) at room temperature for 2 hours. The solid material was filtered and washed twice with acetone (25 ml). The wet solid was dried in a vacuum agitated drier to afford sertraline hydrochloride Form II (20.09 g; yield 98.6 %).

Example 21**Preparation of polymorph II by granulation of V**

Sertraline hydrochloride Form V (2 g) and absolute ethanol (0.5 mL) were stirred in rotavapor at room temperature for 2 days. At the end of two days, the material contained sertraline hydrochloride Form II.

Example 22**Preparation of of polymorph II by drying of the Sertraline hydrochloride form VI**

Sertraline hydrochloride ethanolate-Form VI was dried at 105° C under vacuum (< 10mm Hg) over 24 hours. The resulting dried material was Sertraline hydrochloride Form II mixed with sertraline hydrochloride Form V.

Example 23**Preparation of Sertraline Hydrochloride Form II**

Sertraline base (3 g) was dissolved in acetone (10 mL). Isopropanol containing hydrogen chloride (20 mL) was added to the solution until the pH is ~2. The stirring was continued

over night at room temperature. The resulting solid was filtrated, washed with acetone and dried to yield sertraline hydrochloride Form II (2.61 gr., yield 77.6%).

Example 24

Preparation of Sertraline Hydrochloride Form II

Sertraline hydrochloride Form V (10 gr.) was suspended in dimethylformamide (DMF) (30 mL). The heating was started and at about 70° C a clear solution is obtained. The solution was cooled to room temperature and the solid was filtered. After drying at 80° C for 24hrs. Sertraline hydrochloride Form II was obtained (6.6gr., yield 66%).

Example 25

Preparation of Sertraline Hydrochloride Form X

In a 0.1 liter three-necked bottom round flask equipped with a mechanical stirrer, a condenser and a thermometer, 30 mL benzyl alcohol is added to 10 g sertraline hydrochloride. The suspension is heated to 100°C when a clear solution is obtained. The solution is cooled 2 hours to 25°C and the precipitate is filtered and washed with benzyl alcohol. After drying under vacuum at 80°C for 24 hours, 6.2g of sertraline hydrochloride polymorph X is obtained (yield 62%). The sertraline hydrochloride Form X was characterized by powder x-ray diffraction and infrared absorption analysis as set forth above and in Figure 14 and Figure 15.

Example 26**Preparation of Sertraline Hydrochloride ethanolate Form VI by reslurry of Form I**

Sertraline hydrochloride Form I (1 g) and absolute ethanol (20 mL) were stirred at room temperature for 24 hours. Filtration of the mixture yielded sertraline hydrochloride ethanolate-
5 Form VI.

Example 27**Preparation of Sertraline hydrochloride ethanolate Form VI-by reslurry of Form II**

Sertraline hydrochloride Form II (1 g) and absolute ethanol (20 mL) were stirred at room temperature for 24 hours. Filtration of the mixture yielded sertraline hydrochloride ethanolate
10 Form VI.

Example 28**Preparation of Sertraline Hydrochloride ethanolate -Form VI-by reslurry of Form V**

Sertraline hydrochloride Form V (1 gr.) and ethanol absolute (20 mL.) were stirred at room temperature for 24 hrs. Filtration of the mixture yielded sertraline hydrochloride ethanolate Form VI.
5

Example 29**Preparation of Amorphous Sertraline Hydrochloride**

Sertraline free base (10 g) was dissolved in ethyl acetate (690 mL). At room temperature, ether (690 mL) was added to the sertraline ethyl acetate solution and the solution was
10 acidified with HCl gas to about pH 0.5. The resulting gelatinous suspension was stirred at room

temperature over night. Filtration and air drying of the suspension yielded amorphous sertraline hydrochloride (9.39 gr., yield 83.8%).

Example 30

Preparation of Sertraline Hydrochloride Form III from Form V

5 Sertraline hydrochloride Form V was heated at 150° C in a reactor under mechanical stirring for 24 hrs. The resulting material obtained was sertraline hydrochloride Form III.

Example 31

Preparation of Sertraline Hydrochloride Form III from Form VI

10 Sertraline hydrochloride form VI was heated to 180° C for 24 hours. The dried material is Sertraline hydrochloride Form III.

Example 32

Preparation of Sertraline Hydrochloride Form III from Form V

5 Sertraline hydrochloride Form V was heated at a temperature $\geq 180^{\circ}$ C for 24 hours. The resulting material was Sertraline hydrochloride Form III.

Example 33

Preparation of Amorphous Sertraline Hydrochloride

3 Sertraline hydrochloride Form V (10 g) was dissolved in water (2L) and this solution was dried by the spray dryer technique. The material obtained in this way is Sertraline hydrochloride amorphous.

Example 34**Preparation of Amorphous Sertraline Hydrochloride by Sublimation**

Sertraline hydrochloride Form I was sublimated at 190-200° C , at a vacuum of 30-0.1 mm Hg, using a laboratory -type sublimator. The resulting material was amorphous sertraline hydrochloride.

A similar procedure starting from Form V also gave amorphous sertraline hydrochloride.

Example 35**Preparation of Sertraline Hydrochloride Form V from Amorphous Sertraline**

Sertraline hydrochloride amorphous was heated to 80° C for 24 hours. The resulting product was sertraline hydrochloride Form V.

Example 36**Preparation of Sertraline hydrochloride amorphous by precipitation from toluene.**

Sertraline base (5.8 gr.) was dissolved in toluene (200 mL). HCl gas was bubbled (about pH 1.5) through the solution. A gel is formed. Filtration and drying at 50° C for 16 hours gives amorphous sertraline hydrochloride (6.61gr.).

It should be understood that some modification, alteration and substitution is anticipated and expected from those skilled in the art without departing from the teachings of the invention.

Accordingly, it is appropriate that the following claims be construed broadly and in a manner consistent with the scope and spirit of the invention.

WHAT IS CLAIMED IS:

1. A process for making sertraline hydrochloride Form V comprising the steps of:
 - (a) dissolving sertraline hydrochloride in a suitable solvent;
 - (b) removing the solvent; and
 - (c) drying to form sertraline hydrochloride Form V.
2. The process of claim 1, wherein the solvent is selected from the group consisting of methanol, ethanol, water, methoxypropanol, and, isopropyl alcohol and mixtures thereof.
3. The process of claim 2 wherein the solvent is methanol.
4. The process of claim 2 wherein the solvent is ethanol.
5. The process of claim 2 wherein the solvent is a mixture of isopropyl alcohol and water.
6. The process of claim 1, further comprising the steps of seeding the solution with sertraline hydrochloride Form V.
7. The process of claim 1 wherein the sertraline hydrochloride of step (a) is sertraline hydrochloride Form I.
8. The process of claim 1 wherein the sertraline hydrochloride of step (a) is sertraline hydrochloride Form VI.
9. The process of claim 1 wherein the sertraline hydrochloride of step (a) is sertraline hydrochloride Form VII.

10. The process of claim 1 wherein the sertraline hydrochloride of step (a) is sertraline hydrochloride Form VIII.

11. The process of claim 1 wherein the sertraline hydrochloride of step (a) is sertraline hydrochloride Form IX.

5 12. A process for making sertraline hydrochloride Form V comprising the steps of:

(a) dissolving or suspending sertraline base in a solvent,

(b) adding hydrogen chloride or hydrochloric acid to reduce the pH of the solution or suspension; and

(c) isolating sertraline hydrochloride Form V.

10 13. The process of claim 12 wherein the pH of the solution or suspension of sertraline base and hydrogen chloride or hydrochloric acid is a solvent is about 0 to about 4.

14. The process of claim 12 wherein the solvent is selected from the group consisting of methanol, ethanol, water, ethyl acetate, isopropyl alcohol, hexane, and toluene and mixtures thereof.

15. The process of claim 14 wherein the solvent is methanol.

5 16. The process of claim 14 wherein the solvent is ethanol.

17. The process of claim 14 wherein the solvent is water.

18. The process of claim 14 wherein the solvent is a mixture of hexane and isopropyl alcohol.

19. The process of claim 14 wherein the solvent is a mixture of isopropyl alcohol and water.

20. The process of claim 14 wherein the solvent is a mixture of ethanol and water.

21. The process of claim 14 wherein the solvent is ethyl acetate.

22. The process of claim 14 wherein the solvent is a mixture of ethanol and isopropyl alcohol.

23. The process of claim 14 wherein the solvent is a mixture of methanol and isopropyl alcohol.

24. A pharmaceutical composition comprising a therapeutically effective amount of sertraline hydrochloride Form V and a pharmaceutically acceptable carrier.

25. A process for making sertraline hydrochloride Form V comprising the step of drying sertraline hydrochloride ethanolate Form VI.

26. A process for making sertraline hydrochloride Form V comprising the step of drying sertraline hydrochloride Form VII.

27. A process for making sertraline hydrochloride Form V comprising the step of drying sertraline hydrochloride hydrate Form VIII.

28. A process for making sertraline hydrochloride Form V comprising the steps of:

(a) suspending or dissolving sertraline hydrochloride in a solvent selected from the group consisting of ethanol, methanol and water and mixtures thereof; and

(b) isolating sertraline hydrochloride Form V.

29. A process for making sertraline hydrochloride Form V comprising the steps of:

5 (a) dissolving sertraline hydrochloride Form VI in water;

(b) adding a sufficient amount of hydrochloric acid or hydrogen chloride to facilitate precipitation of sertraline hydrochloride Form V;

(c) removing the water; and

(d) isolating sertraline hydrochloride Form V.

30. A process for making sertraline hydrochloride Form V comprising the steps of:

0 (a) heating amorphous sertraline hydrochloride for a time sufficient to effect the transformation to sertraline hydrochloride Form V; and

(b) isolating sertraline hydrochloride Form V.

31. The process of claim 30 wherein amorphous sertraline hydrochloride is heated to a temperature up to about 80° C.

32. Sertraline hydrochloride Form VI.

33. Sertraline hydrochloride Form VI ethanolate.

34. Sertraline hydrochloride Form VI methanolate.

35. Sertraline hydrochloride Form VI, which is characterized by an x-ray powder diffraction pattern comprising peaks at about $7.3^{\circ} \pm 0.2$, $12.1^{\circ} \pm 0.2$, $12.7^{\circ} \pm 0.2$, $22.0^{\circ} \pm 0.2$, $22.9^{\circ} \pm 0.2$, $23.2^{\circ} \pm 0.2$, $24.0^{\circ} \pm 0.2$, and $24.5^{\circ} \pm 0.2$ degrees two-theta.

36. A pharmaceutical composition comprising a therapeutically effective amount of sertraline hydrochloride Form VI and a pharmaceutically acceptable carrier.

37. A process for making sertraline hydrochloride Form VI comprising the steps of:

- (a) dissolving sertraline base in a solvent;
- (b) adding hydrogen chloride gas to the solution; and
- (c) isolating sertraline hydrochloride Form VI without further drying.

38. The process of claim 37 wherein the isolation step comprises precipitation of sertraline hydrochloride Form VI followed by filtration.

39. The process of claim 37 wherein the solvent is ethanol or methanol.

40. The product of the process of claim 37.

41. A process for making sertraline hydrochloride Form VI comprising the steps of:

- (a) dissolving sertraline hydrochloride in ethanol or methanol;
- (b) stirring for a time sufficient to induce the transformation of sertraline

hydrochloride to sertraline hydrochloride Form VI; and

- (c) isolating sertraline hydrochloride Form VI.

42. The process of claim 41 wherein the sertraline hydrochloride of step (a) is Form I.

43. The process of claim 41 wherein the sertraline hydrochloride of step (a) is Form II.

44. The process of claim 41 wherein the sertraline hydrochloride of step (a) is Form V.

45. Sertraline hydrochloride Form VII.

46. A pharmaceutical composition comprising a therapeutically effective amount of
5 sertraline hydrochloride Form VII, and a pharmaceutically acceptable carrier.

47. A process for making sertraline hydrochloride Form VII comprising the steps of:

- (a) suspending sertraline hydrochloride Form V in water; and
- (b) filtering the suspension without drying.

48. The product of the process of claim 47.

0 49. A process for making sertraline hydrochloride Form VII comprising the steps of:

(a) dissolving sertraline hydrochloride ethanolate Form VI in water such that the
sertraline hydrochloride Form VI is converted to sertraline hydrochloride Form VII;

- (b) filtering the sertraline hydrochloride Form VII; and
- (c) washing the filtered sertraline hydrochloride Form VII with water.

5 50. A process for making sertraline hydrochloride Form VII comprising the steps of:

- (a) dissolving sertraline hydrochloride ethanolate Form VI in water;
- (b) heating the solution to facilitate dissolution of sertraline hydrochloride Form VI;
and
- (c) isolating sertraline hydrochloride Form VII without drying.

51. The process of claim 50 comprising the additional step of lowering the pH to facilitate precipitation of sertraline hydrochloride Form V.

52. Sertraline hydrochloride Form VII, which is characterized by the x-ray powder diffraction pattern substantially depicted in Figure 6.

5 53. Sertraline hydrochloride hydrate Form VIII.

54. Sertraline hydrochloride Form VIII, which is characterized by an x-ray powder diffraction pattern comprising peaks at about $4.7^{\circ} \pm 0.2$, $16.3^{\circ} \pm 0.2$, $17.8^{\circ} \pm 0.2$, $19.6^{\circ} \pm 0.2$, $23.2^{\circ} \pm 0.2$, $24.2^{\circ} \pm 0.2$, $25.1^{\circ} \pm 0.2$, and $26.0^{\circ} \pm 0.2$ two-theta.

0 55. A pharmaceutical composition comprising a therapeutically effective amount of sertraline hydrochloride Form VIII, and a pharmaceutically acceptable carrier.

56. A process for making sertraline hydrochloride Form VIII comprising the steps of:

- (a) suspending sertraline base in water;
- (b) adding hydrochloric acid; and
- (c) filtrating the precipitate so obtained without further drying.

5 57. The product of the process of claim 58.

58. A process for making sertraline hydrochloride Form VIII comprising the steps of:

- (a) dissolving sertraline hydrochloride ethanolate Form VI in water; and
- (b) isolating sertraline hydrochloride Form VIII.

59. A process for making sertraline hydrochloride Form VIII comprising the steps of:

- (a) dissolving sertraline hydrochloride Form II in water; and
- (b) isolating sertraline hydrochloride Form VIII.

60. Sertraline hydrochloride Form IX, which is characterized by the x-ray diffraction pattern substantially as depicted in Figure 8.

5 61. Sertraline hydrochloride Form IX, which is characterized by an x-ray powder diffraction pattern comprising peaks at about $5.1^{\circ} \pm 0.2$, $14.2^{\circ} \pm 0.2$, $15.8^{\circ} \pm 0.2$, $16.8^{\circ} \pm 0.2$, $19.2^{\circ} \pm 0.2$, $19.7^{\circ} \pm 0.2$, $22.4^{\circ} \pm 0.2$, $23.2^{\circ} \pm 0.2$, $25.3^{\circ} \pm 0.2$ and $26.1^{\circ} \pm 0.2$ two-theta.

62. A pharmaceutical composition comprising a therapeutically effective amount of sertraline hydrochloride Form IX, and a pharmaceutically acceptable carrier.

0 63. A process for making sertraline hydrochloride Form IX comprising the steps of:

- (a) suspending sertraline base in water;
- (b) adding hydrochloric acid such that a precipitate is formed;
- (c) filtrating the precipitate; and
- (d) drying the precipitate.

5 64. The product of the process of claim 63.

65. A process for making sertraline hydrochloride Form IX comprising the step of drying sertraline hydrochloride Form VIII and isolating sertraline hydrochloride Form IX.

66. A process for making sertraline hydrochloride Form X comprising the steps of:

- (a) suspending sertraline hydrochloride in benzyl alcohol;

- (b) heating the suspension to facilitate dissolution;
- (c) cooling the solution such that a precipitate is formed;
- (d) heating the solution to about 80°C; and
- (e) isolating sertraline hydrochloride Form X.

5 67. The process of claim 66 wherein the sertraline hydrochloride Form X is isolated by filtration and washing with benzyl alcohol and heating.

68. The product of the process of claim 66.

69. Sertraline hydrochloride Form X.

70. Sertraline hydrochloride Form X which is characterized by an x-ray powder diffraction pattern comprising peaks at about 15.0° ±0.2, 16.0° ±0.2, 16.5° ±0.2, 17.0° ±0.2, 18.1° ±0.2, 21.0° ±0.2, 22.4° ±0.2, 24.9° ±0.2, 25.4° ±0.2, 26.2° ±0.2, 27.1° ±0.2, 28.4° ±0.2, and 29.0° ±0.2 degrees two-theta.

71. A pharmaceutical composition comprising a therapeutically effective amount of sertraline hydrochloride Form X, and a pharmaceutically acceptable carrier.

72. A process for making sertraline hydrochloride Form II comprising the steps of:

- (a) suspending sertraline hydrochloride Form VI in an organic aprotic solvent for a time sufficient to effect transformation to Form II; and
- (b) filtrating the suspension.

73. The process of claim 72 wherein the process takes place at temperature between about 25° C and about 80° C.

74. The process of claim 72 in which the sertraline hydrochloride form VI is suspended in about 1 to about 10 volumes of organic aprotic solvent.

5 75. The process of claim 72 wherein the solvent is selected from the group consisting of acetone, t-butyl-methyl-ether, cyclohexane, and ethyl acetate.

76. The process of claim 77 wherein the solvent is t-butyl-methyl-ether.

77. The process of claim 77 wherein the solvent is acetone.

78. A process for making sertraline hydrochloride Form II comprising the steps of:

- (a) suspending sertraline hydrochloride Form V in dimethylformamide or cyclohexanol;
- (b) heating the solution for a time sufficient to effect transformation to sertraline hydrochloride Form II; and

(c) isolating sertraline hydrochloride Form II.

79. A process for making sertraline hydrochloride Form II comprising the steps of:

- (a) dissolving sertraline base in acetone;
- (b) adding a hydrogen chloride solution to induce the formation of sertraline hydrochloride Form II; and
- (c) isolating sertraline hydrochloride Form II.

80. A process for making sertraline hydrochloride Form II comprising the steps of:

- (a) granulating sertraline hydrochloride Form V with ethanol; and
- (b) stirring the mixture for a time sufficient to induce transformation to sertraline hydrochloride Form II.

5 81. A process for making a mixture of sertraline hydrochloride Form II and Form V comprising the steps of:

- (a) heating sertraline hydrochloride ethanolate Form VI at up to 1 atmosphere pressure; and
- (b) isolating a mixture of sertraline hydrochloride Form II and Form V.

82. The process of claim 81 wherein the sertraline hydrochloride Form VI is heated to about 80°C to about 105°C.

83. A process for making sertraline hydrochloride Form III comprising the steps of:

- (a) heating sertraline hydrochloride Form V for a time sufficient to induce the transformation of sertraline hydrochloride Form II to sertraline hydrochloride Form V; and
- (b) isolating sertraline hydrochloride Form III.

84. The process of claim 83 wherein sertraline hydrochloride Form V is heated to about 150° C to about 180° C.

85. A process for making sertraline hydrochloride Form III comprising the steps of:

(a) heating sertraline hydrochloride Form VI for a time sufficient to induce the transformation of sertraline hydrochloride Form V to sertraline hydrochloride Form III; and

(b) isolating sertraline hydrochloride Form III.

86. The process of claim 85 wherein sertraline hydrochloride is heated to about 180° C.

5 87. A process for making amorphous sertraline hydrochloride comprising the steps of:

(a) suspending or dissolving sertraline base in a non-polar organic solvent;

(b) adding gaseous hydrochloric acid; and

(c) and isolating amorphous sertraline hydrochloride.

88. The process of claim 87 wherein the solvent is selected from the group consisting of
0 ether, toluene and t-butyl-methyl ether.

89. A process for making amorphous sertraline hydrochloride comprising the steps of:

(a) lyophilization of sertraline hydrochloride; and

(b) isolating amorphous sertraline hydrochloride.

90. Amorphous sertraline hydrochloride, which is characterized by the x-ray diffraction
5 pattern substantially as depicted in Figure 2.

XRD ANALYSIS 9/30

Sample: 7011
Date: 10.02.01
Sample: CTR Ar 95.90
Wt: 10
Vol: 28
Target: Co Ni
Detector: Scintile
Voltage: 352
Current: 950
Wavelength: 409
Scanning Speed: 0.5
Power: 10.42
Scan: 32
PC: 2
S/N: 1
On: 02
Scan: 1

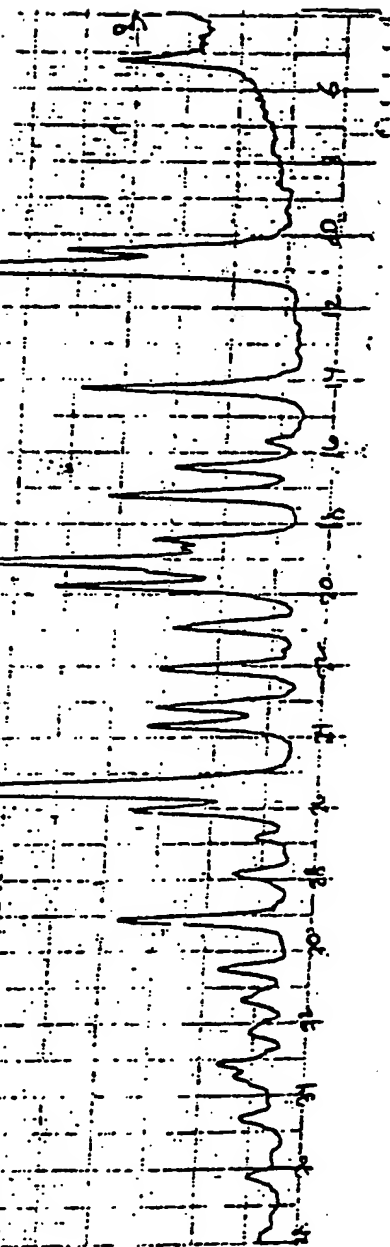


Figure 1

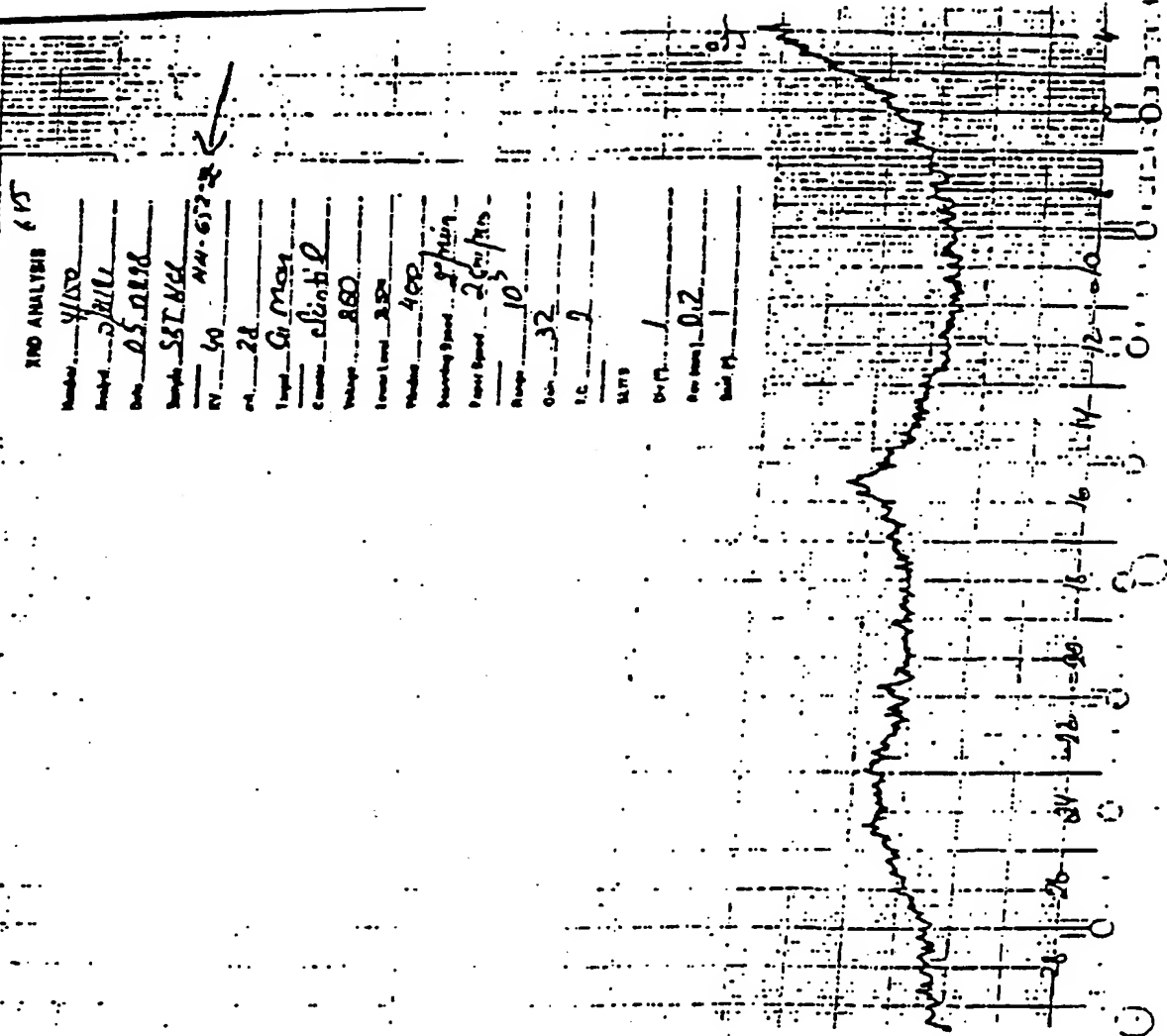


Figure 2

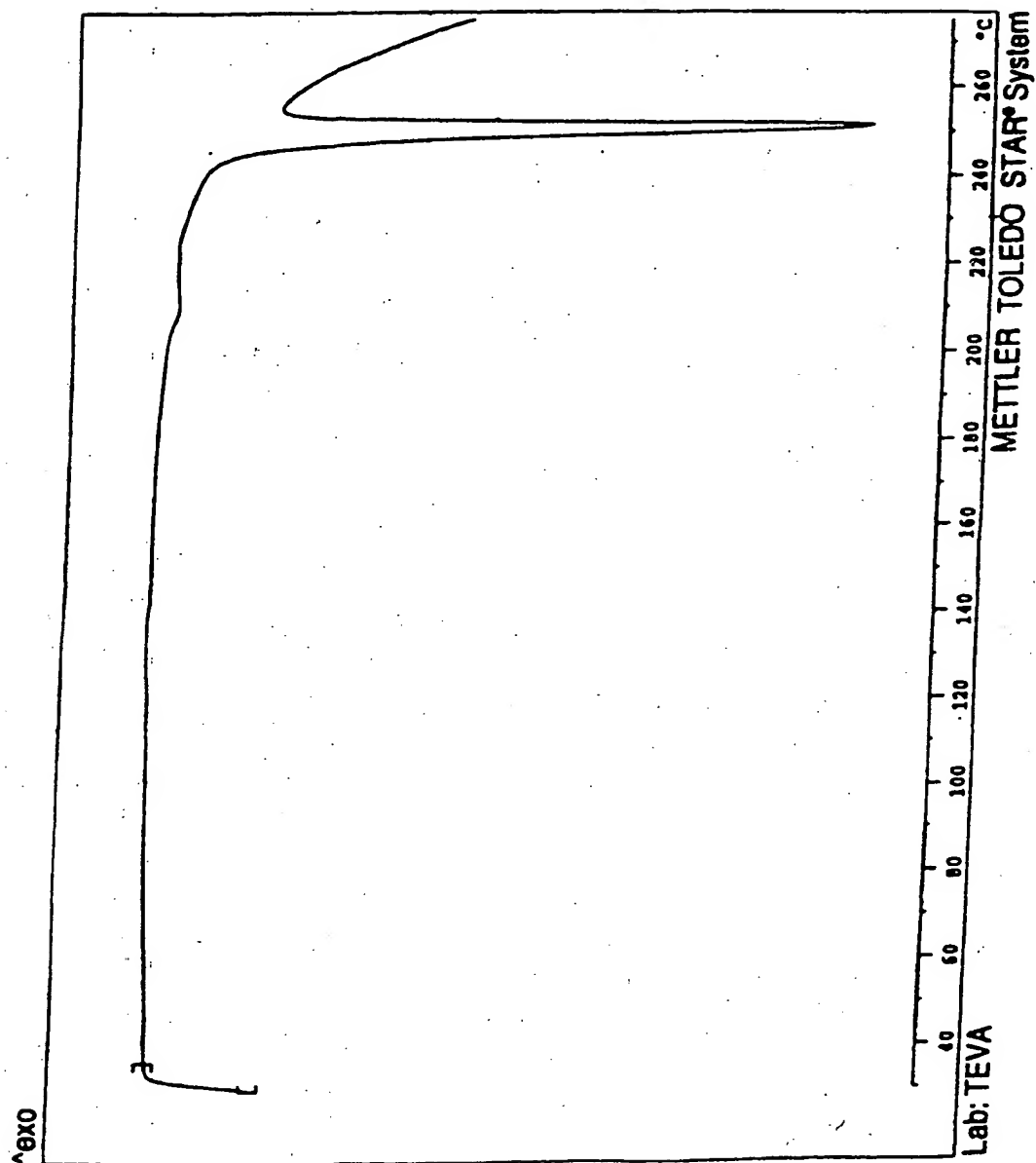
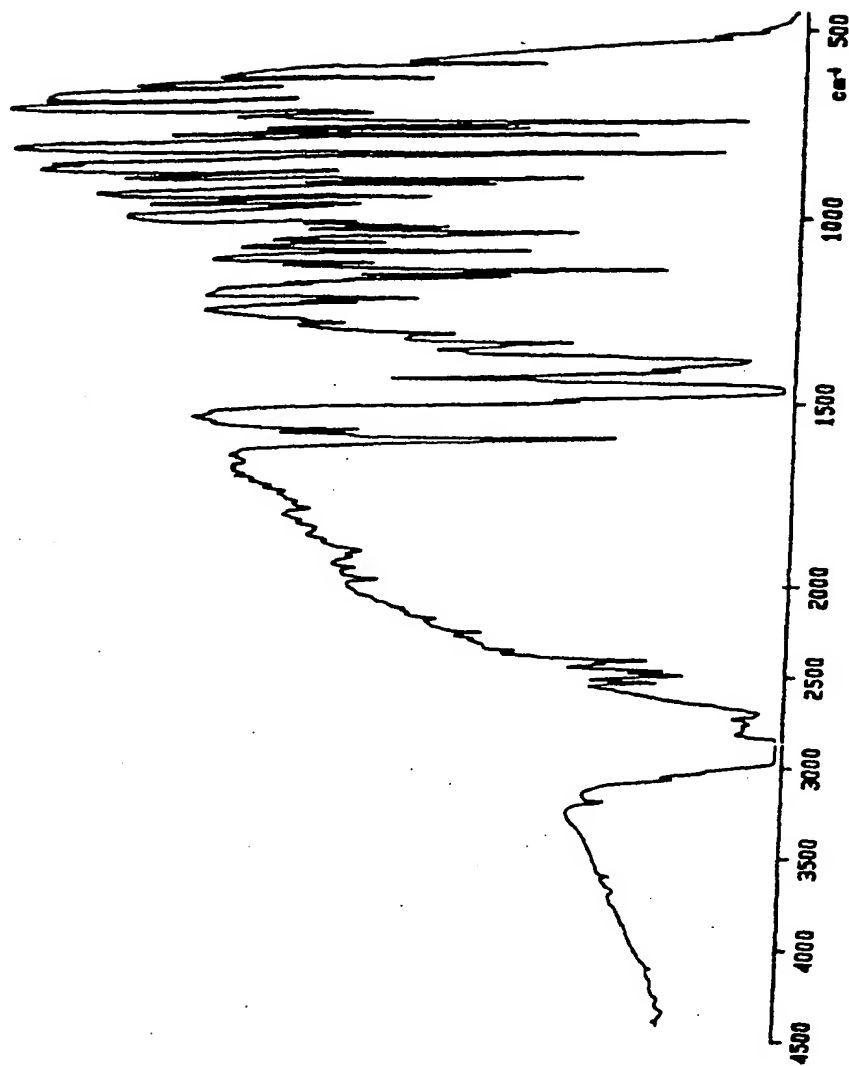
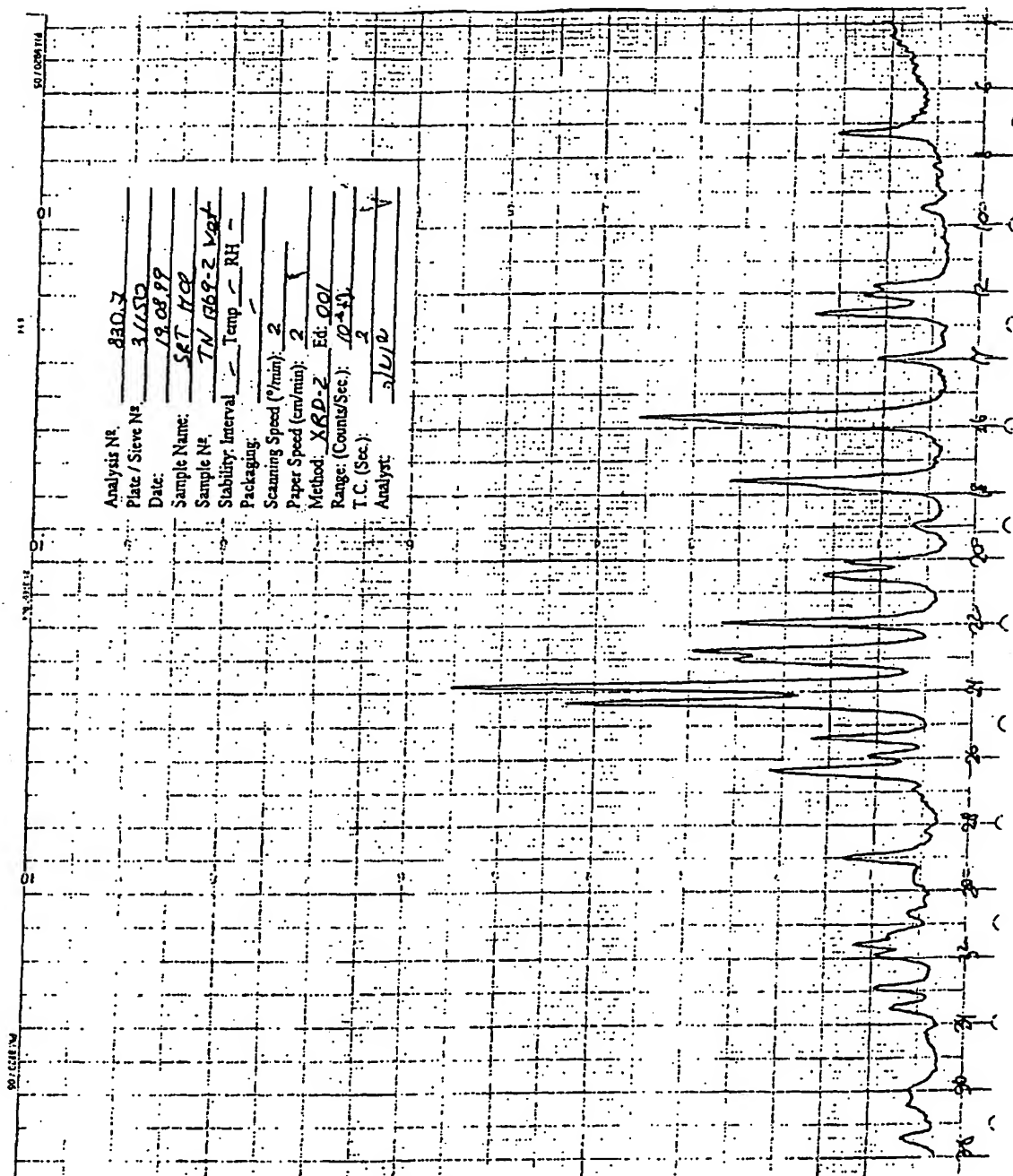


Figure 3



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acrtaline hcl at 9690

Figure 4



XRD data for form VI

Figure 5

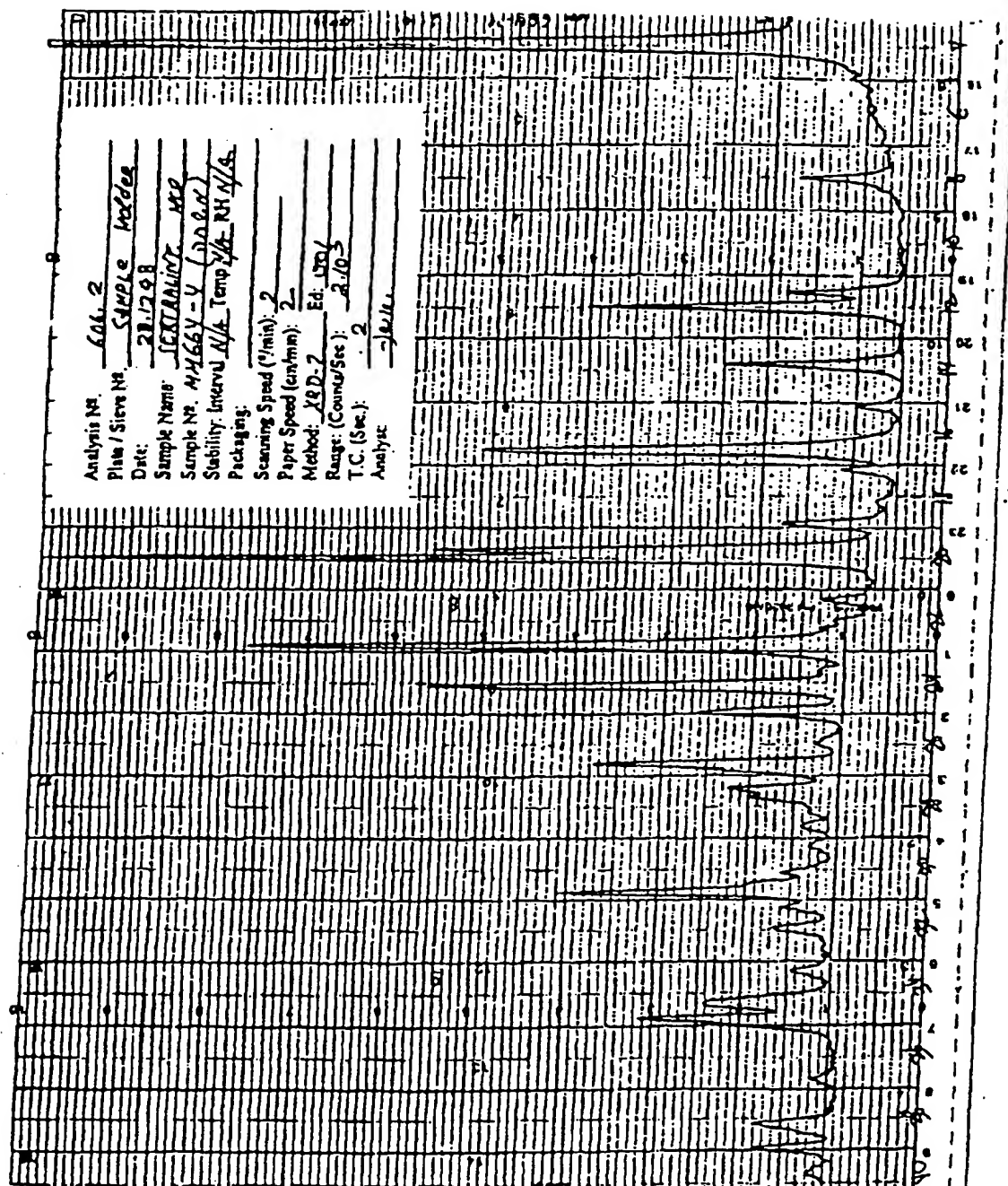


Figure 6

Fig 7

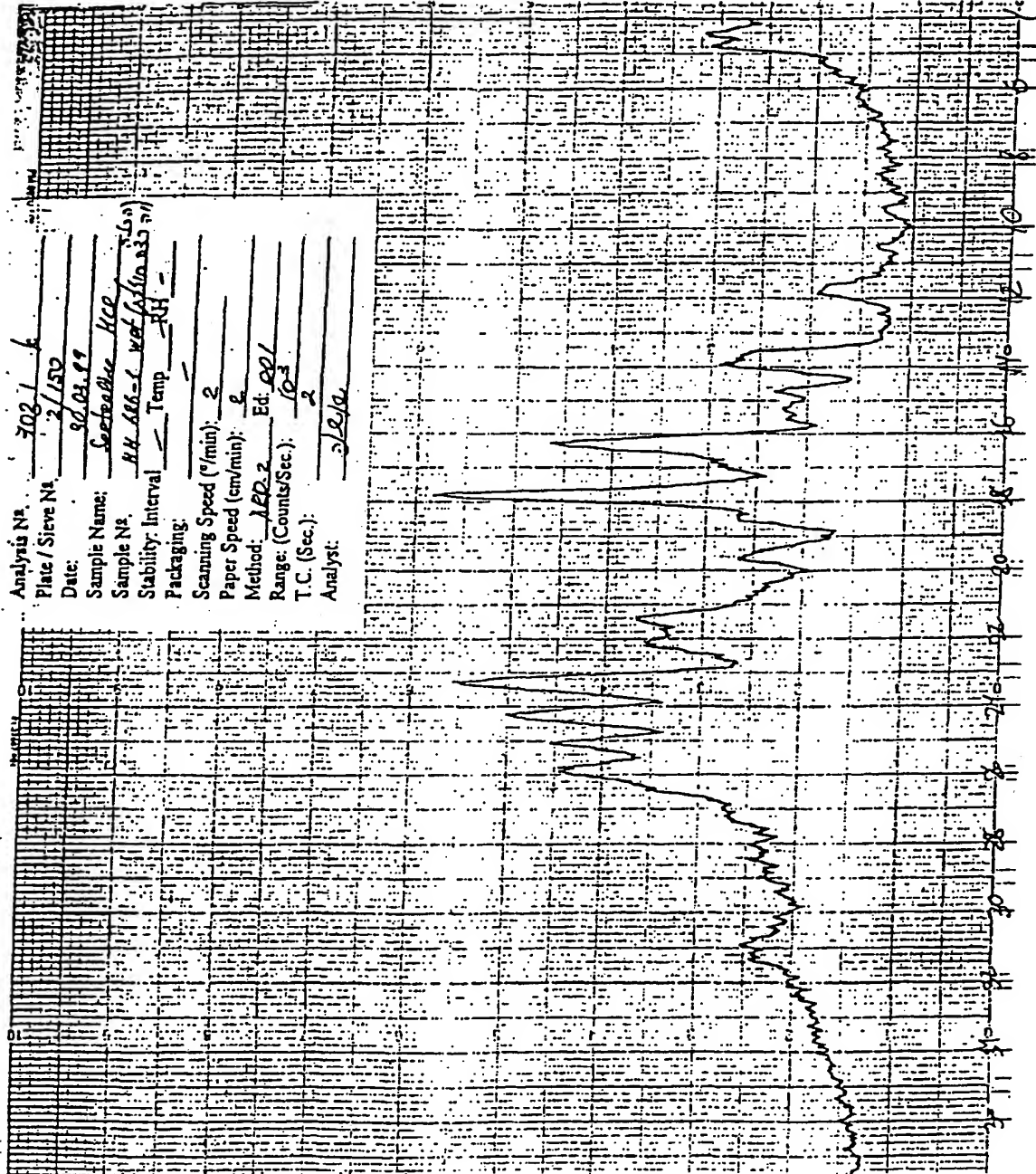


Fig 8

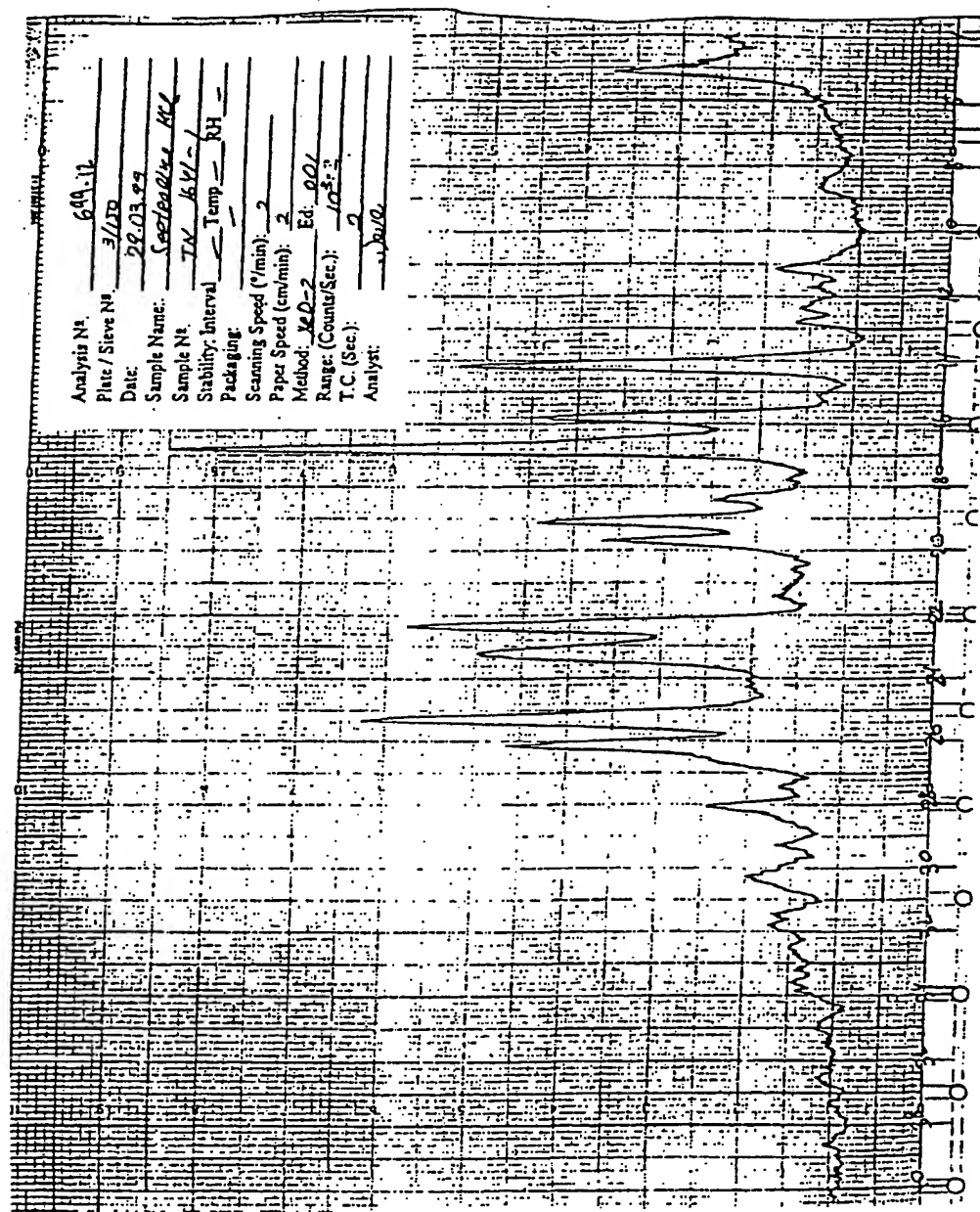


Fig 9

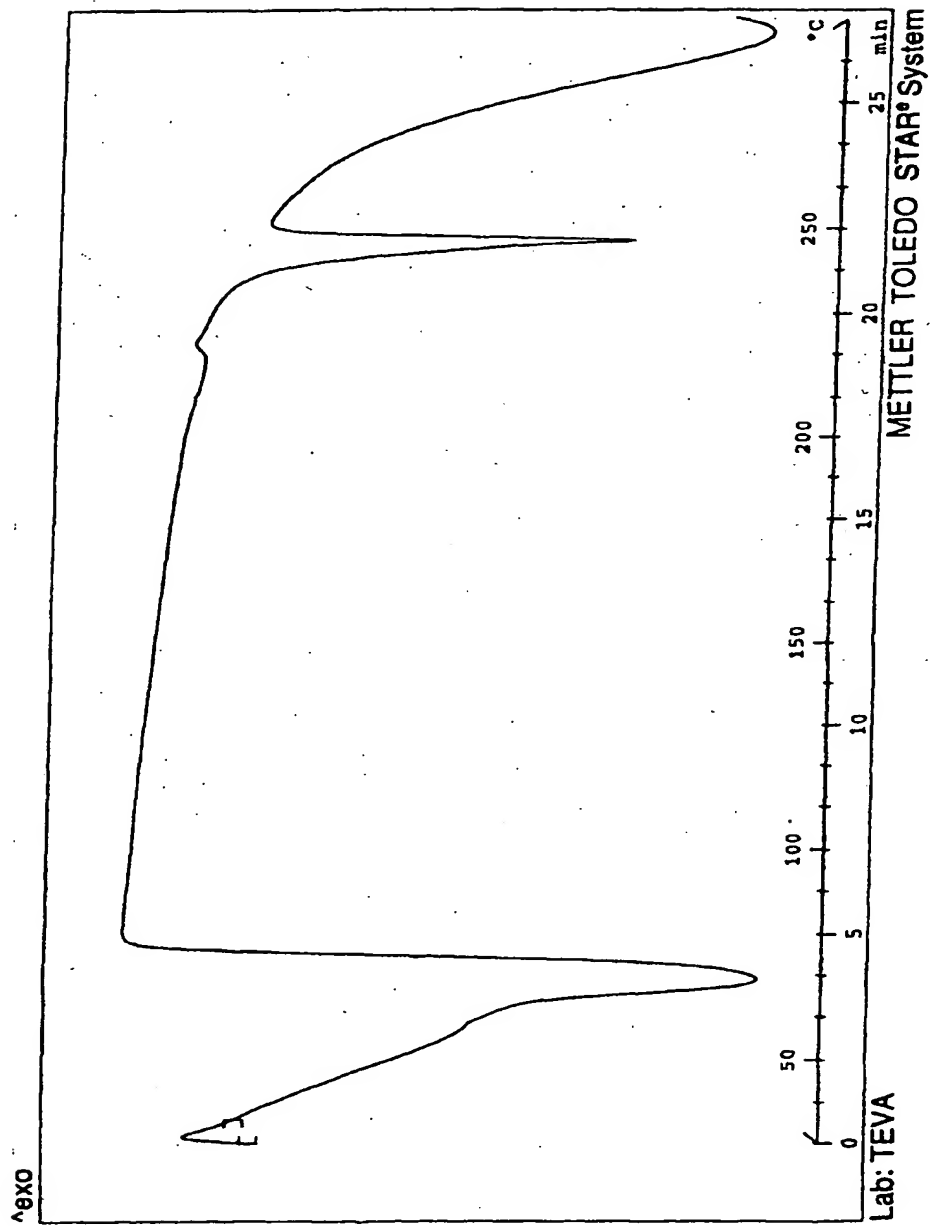


Fig. 10

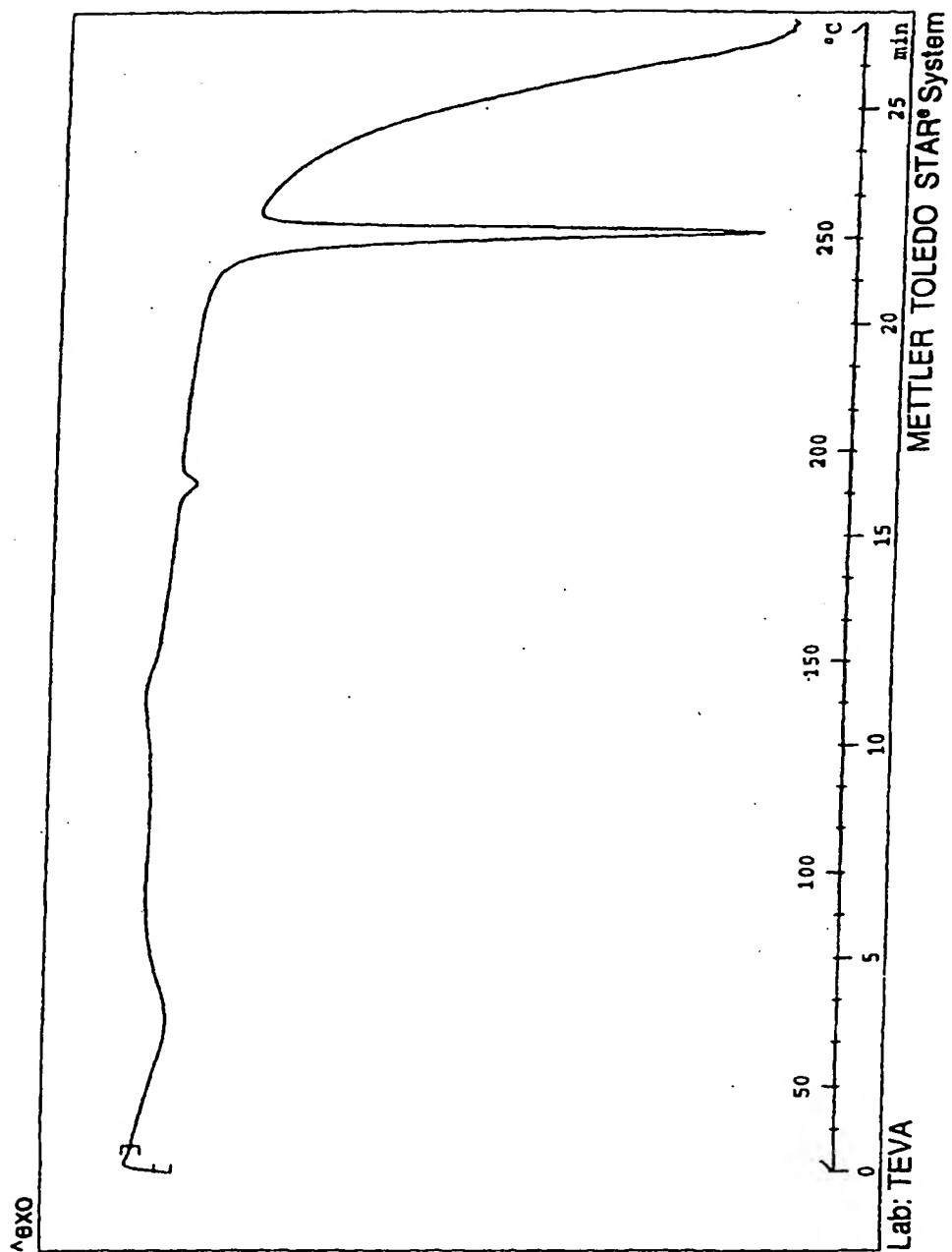


Fig 11

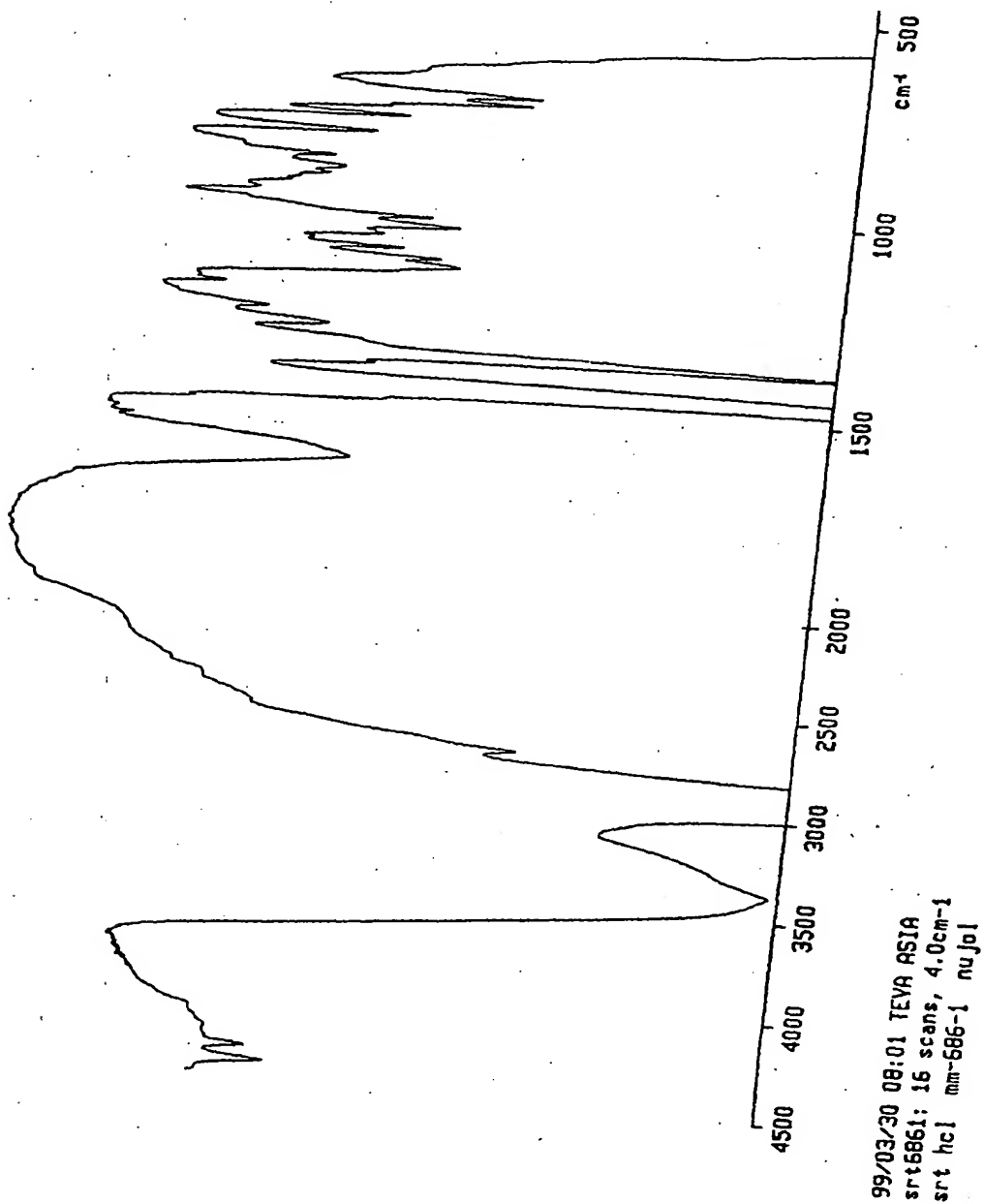
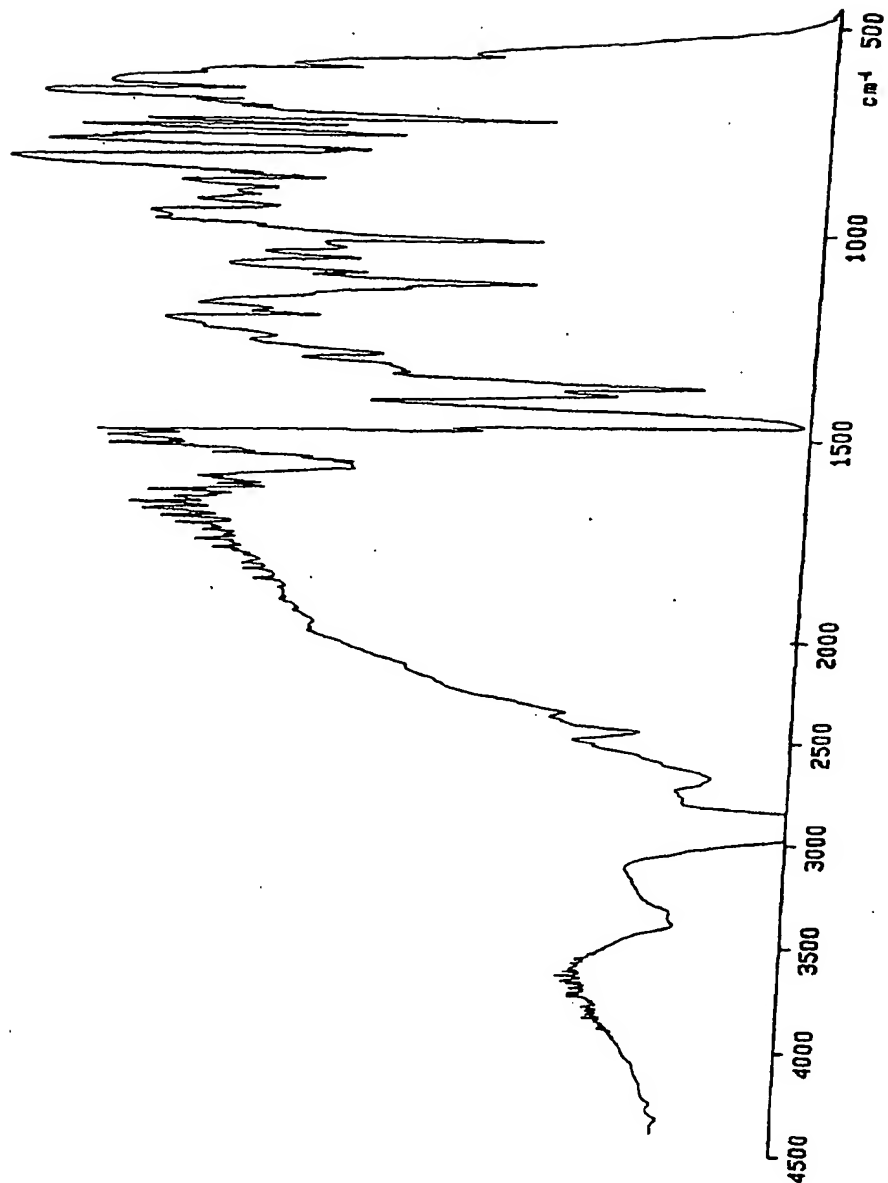
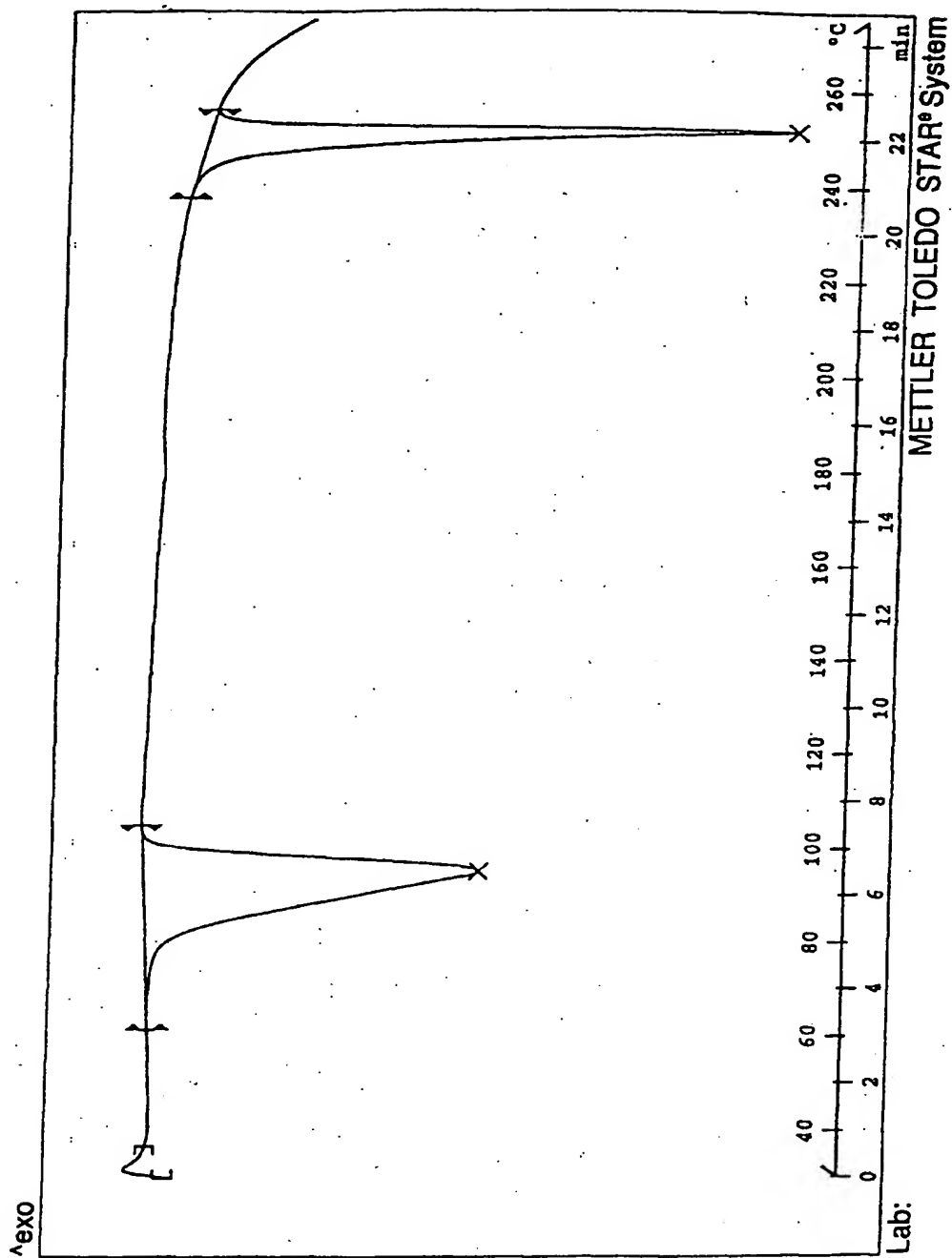


Fig 12



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art hcl tn 1641-1 nujol



DSC of form VI ethanolate

FIGURE 13

Thursday 18 November 1999

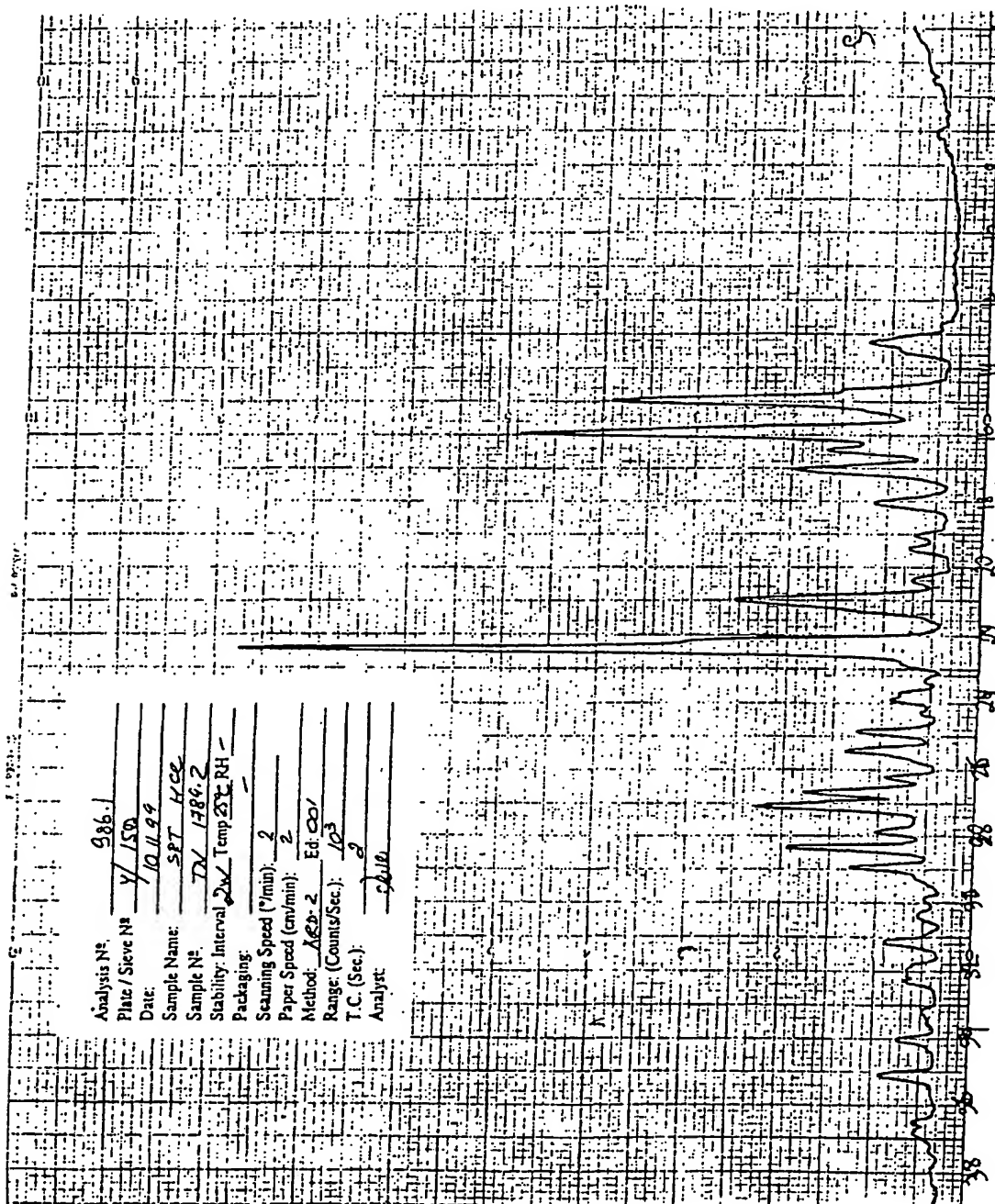
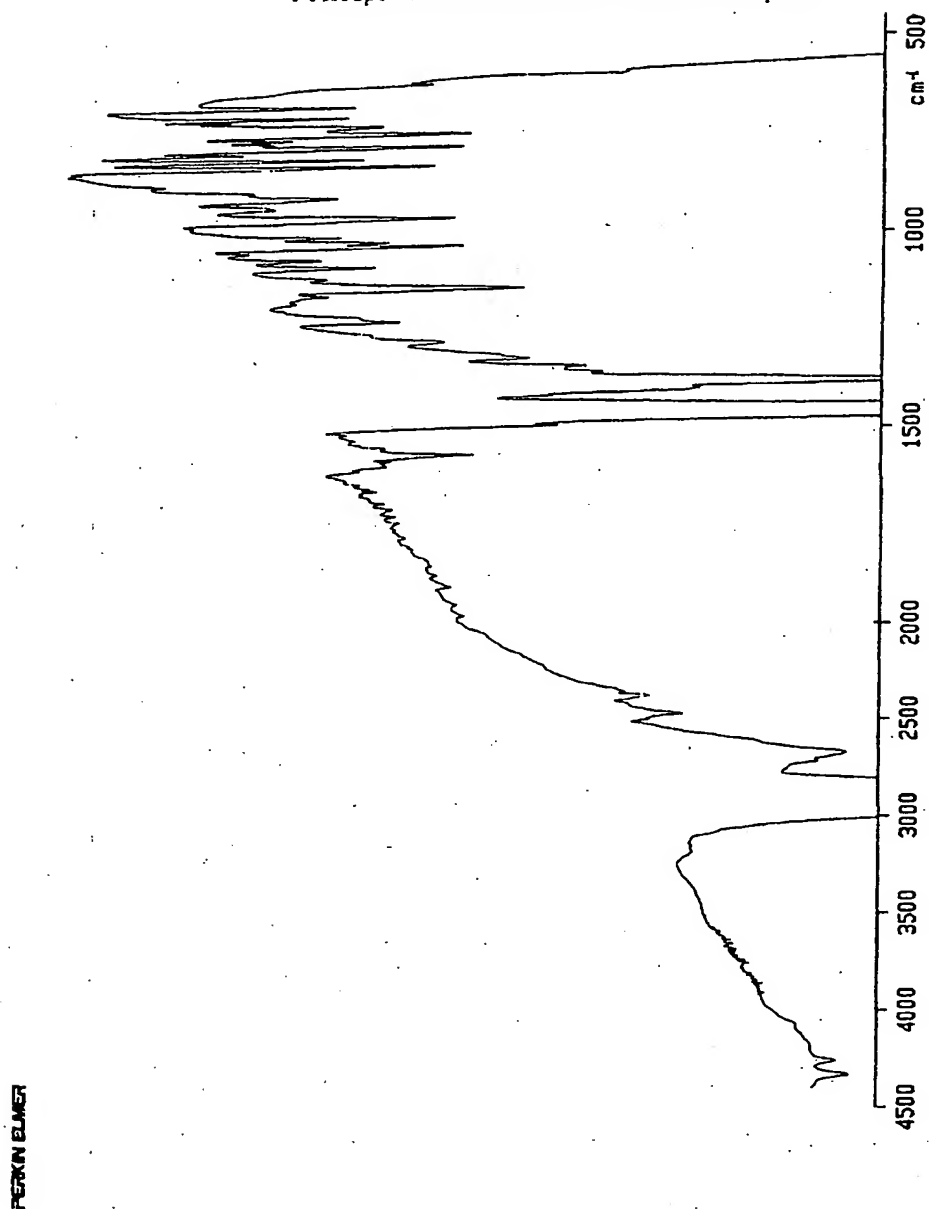
X-Ray powder diffractogram of Sertraline HCl novel form X for patent

FIGURE 14

FTIR spectrum of Sertraline HCl form X for patent



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srt1: 16 scans, 4.0cm-1
sertraline srt.hcl tn-1789-2 25dg.c 2w

FIGURE 15

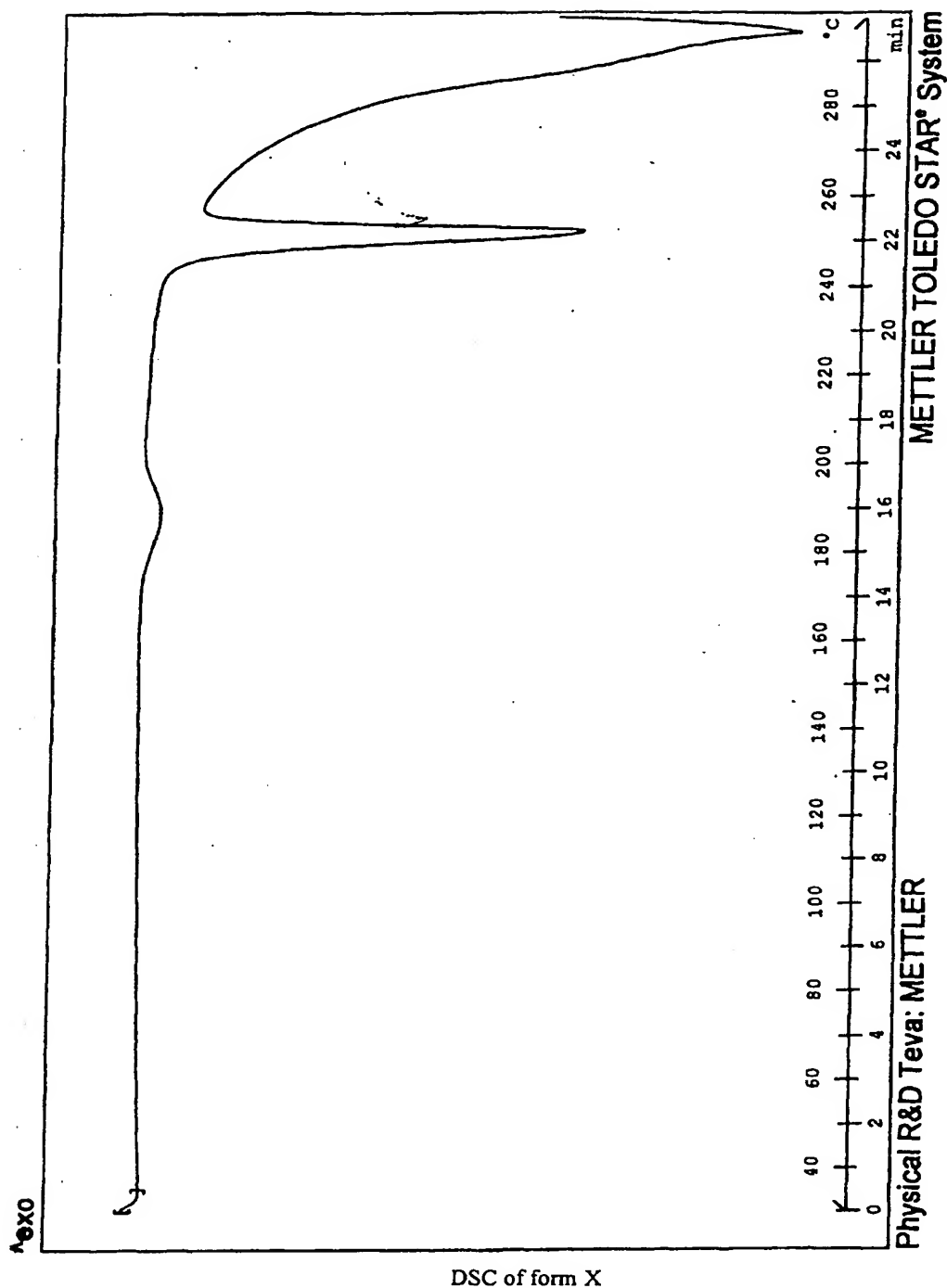


FIGURE 16

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US99/27881

A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) : C07C 87/64

US CL : 514/647; 564/308

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 514/647; 564/308

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
NONEElectronic data base consulted during the international search (name of data base and, where practicable, search terms used)
STN

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 4,536,518 A (WELCH, JR. et al) 20 August 1985(20.08.85).	1-90
A	US 5,082,970 A (BRAISH) 21 January 1992 (21.01.92).	1-90
A	US 5,463,126 A (WILLIAMS) 31 October 1995 (31.10.95).	1-90

☐ Further documents are listed in the continuation of Box C. ☐ See patent family annex.

* Special categories of cited documents:	*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
E earlier document published on or after the international filing date	*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	*Z* document member of the same patent family
O document referring to an oral disclosure, use, exhibition or other means	
P document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

12 APRIL 2000

Date of mailing of the international search report

25 APR 2000

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Facsimile No. (703) 305-3230

Authorized officer

SAMUEL BARTS

Telephone No. (703) 308-1235

JOYCE BRIDGERS
PARALEGAL SPECIALIST
CHEMICAL MATRIX

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